State of Montana
Department of Environmental Quality
Helena, Montana 59620

AIR QUALITY OPERATING PERMIT NUMBER OP1564-01

Significant Modification Application Received: **February 13, 2002**
Application Deemed Administratively Complete: **March 13, 2002**
Application Deemed Technically Complete: **December 17, 2002**
AFS Number: **030-111-0013A**

Draft Issue Date: **November 3, 2003**
Proposed Issue Date: **April 29, 2004**
End of EPA 45-day Review: **June 17, 2004**
Date of Decision: **June 18, 2004**
Effective Date: **July 20, 2004**
Expiration Date: **December 2, 2006**

In accordance with Montana Code Annotated sections 75-2-217 and 218, and Administrative Rules of Montana (ARM), Title 17, Chapter 8, Subchapter 12, Operating Permit Program, ARM 17.8.1201, *et seq.*,

ExxonMobil Refining and Supply Company
Billings Refinery
S ½ of Section 24 and N ½ of Section 25, Township 1 North, Range 25 East, Yellowstone County
P.O. Box 1163
Billings, MT 59103-1163

hereinafter referred to as "ExxonMobil," is authorized to operate a stationary source of air contaminants consisting of the emission units described in this permit. Until this permit expires or is modified or revoked, ExxonMobil is allowed to discharge air pollutants in accordance wit the conditions of this permit. All conditions in this permit are federally and state enforceable unless otherwise specified. Requirements that are only state enforceable are identified in the permit. A copy of this permit must be kept on site at the above-named facility.

Issued by the Department of Environmental Quality

_____ __/__/__
Signature Date

Permit Issuance and Appeal Processes: In accordance with ARM 17.8.1210(j), the Department of Environmental Quality's (Department) decision regarding issuance of an operating permit is not effective until 30 days have elapsed from the date of the decision issued June 18, 2004. The decision may be appealed to the Board of Environmental Review by filing a request for a hearing within 30 days after the date of decision. If no appealed is filed then the Department will send notification and a final permit cover page to be attached to this document stating that the permit is final. In addition, ARM 17.8.1233 allows for any person to petition the Environmental Protection Agency (EPA) within 60 days after the expiration of EPA's 45-day review period to object to issuance of this operating permit. If EPA objects to the operating permit as a result of a petition prior to the Department's notification of a final permit, ExxonMobil and all affected parties will be informed of the stay of a final permit. If the Department has already notified ExxonMobil and all affected parties, the Department shall issue a revised permit according to ARM 17.8.1231. Questions regarding the final issuance date and status of appeals should be directed to the Department at (406) 444-3490.

Montana Air Quality Operating Permit
Department of Environmental Quality

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Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit have the meaning assigned to them in the referenced regulations. Whenever there are conflicting definitions within this permit, the definition of terms used in ARM 17.8.1201 shall control.

SECTION I. GENERAL INFORMATION

The following general information is provided pursuant to ARM 17.8.1210(1).

Company Name: **ExxonMobil Refining and Supply, a division of Exxon Mobil Corporation (or sometimes referred to as "ExxonMobil Billings Refinery")**

Mailing Address: **P.O. Box 1163**

City: **Billings** State: **Montana** Zip: **59103-1163**

Pb lant Location: **700 Exxon Road**

Responsible Official: **Bruce J. Brodie** Phone: **(406) 657-5380**

Facility Contact Person: **B. M. Gieser** Phone: **(406) 657-5343**

Primary SIC Code: **2911**

Nature of Business: **Petroleum Refining**

Description of Process: **ExxonMobil Refining and Supply Company (ExxonMobil) operates a petroleum refinery designed to process high sulfur crude oil. The major processing equipment includes:**

1. **Atmospheric and vacuum crude distillation towers**
2. **Fluidized Catalytic Cracker**
3. **Hydrocracker and Hydrogen Plant**
4. **Fluid Coker**
5. **Naphtha Fractionator**
6. **Catalytic Reformer**
7. **Hydrofluoric Alkylation Unit**
8. **Three Hydrotreaters for polishing the naphtha and distillate streams**

ExxonMobil does not have a sulfur recovery unit at this refinery. Refinery gases high in H_2S are piped to an off-site sulfur recovery plant owned and operated by the Montana Sulphur and Chemical Company (MSCC). MSCC has an Amine unit to treat the sour refinery fuel gas and return the sweet refinery fuel gas to ExxonMobil. The refinery and the bulk terminal are considered one facility for the purpose of any permitting completed in accordance with the New Source Review Program.

SECTION II. SUMMARY OF EMISSION UNITS

The emission units regulated by this permit are the following (ARM 17.8.1211):

Unit ID	Descriptions	Pollution Control Device/Practices
EU01	Crude – APS and VPS	None
	EU01a: F-2 Heater Stack (F-1 Crude Furnace/F-401 Vacuum Heater)	CEMS on Fuel Gas Header
	EU01b: F-3 Heater Stack	CEMS on Fuel Gas Header
	EU01c: D-4 Drum Atmospheric Stack	None
EU02	HF #2/3 – Hydrofining Units #2 and #3	None
	EU02a: F-3x Heater Stack	CEMS on Fuel Gas Header
	EU02b: F-5 Heater Stack	CEMS on Fuel Gas Header
EU03	Coker – Fluid Coker	YELP, Multiclone, Opacity
	EU03a: KCOB – Coker CO Boiler Stack	CEMS on Fuel Gas Header
	EU03b: F-202 – Heater Stack	CEMS on Fuel Gas Header
EU04	POFO – Powerforming Unit	None
	EU04a: F-700 Heater Stack	CEMS on Fuel Gas Header
EU05	Alky/Splitter/Rerun/Diene – Alkylation Unit, Alky Feed Treater, Rerun of Alkylate for Avgas	None
	EU05a: F-402 Heater Stack	CEMS on Fuel Gas Header
EU06	Treater – Cat Naphtha Caustic Treater (Merox Unit) after Cat Cracker	None
EU07	HF#1	None
	EU07a: F-201 Heater Stack	CEMS on Fuel Gas Header
EU08	DEC2 – Deethanizaer Unit	None
EU09	FCCU – Cat Cracking Unit	None
	EU09a: CCOB Stack – Cat CO Boiler	Opacity Monitor, SO_2 CEMS – SWSOH sent to FCC CO Boiler
EU10	ULEB/SLEB – Unsaturated Light Ends Unit, Saturated Light Ends Unit, Sour Water Strippers, Gas Compression	None
EU11	HCBL – Hydrocracking Unit	None
	EU11a: F-651 – Heater Stack	CEMS on Fuel Gas Header
EU12	H_2 Plant/HRUB – H_2 Plant, H_2 Upgrade (Recovery) Facility, MDU Replacement	None
	EU12a: F-551 Heater Stack	CEMS on Fuel Gas Header
EU13	Utilities – Air Compressors/Dryers, Boiler Feed Water System	None
	EU13a: B-8 Backup Boiler Stack	CEMS on Fuel Gas Header
EU14	OM&U – Oil Movements and Utilities, Wastewater, High Pressure Natural Gas, Refinery Gas Supply	CEMS on Fuel Gas Header
	EU14a: Flare – Flare and Turnaround Flare	Steam assisted
	EU14b: F-10 Heater Stack	Fires only natural gas
EU15	OM&S/PMAU – Oil Movements & Shipping/Asphalt PMAU	None
EU16	Low Sulfur Mogas	None
	EU16a: F-1201 Heater Stack	CEMS on Fuel Gas Header and Ultra-Low NO_x Burners

SECTION III. PERMIT CONDITIONS

The following requirements and conditions are applicable to the facility or to specific emission units located at the facility (ARM 17.8.1211, 1212, and 1213).

A. Facility-Wide

Conditions	Rule Citations	Rule Description	Pollutant/Parameters	Limit
A.1	ARM 17.8.106	Source Testing Protocol	Testing, Recordkeeping, and Reporting Requirements	-------
A.2	ARM 17.8.304(1)	Visible Air Contaminants	Opacity	40%
A.3	ARM 17.8.304(2)	Visible Air Contaminants	Opacity	20%
A.4	ARM 17.8.304(3)	Visible Air Contaminants	Opacity	60%
A.5	ARM 17.8.308(1)	Particulate Matter, Airborne	Fugitive – Opacity	20%
A.6	ARM 17.8.308(2)	Particulate Matter, Airborne	Reasonable Precautions	-------
A.7	ARM 17.8.308(3)	Particulate Matter, Airborne	Reasonable Precaution, Construction	20%
A.8	ARM 17.8.309	Particulate Matter, Fuel Burning Equipment	Particulate Matter	$E = 0.882 * H^{-0.1664}$ or $E = 1.026 * H^{-0.233}$
A.9	ARM 17.8.310	Particulate Matter, Industrial Processes	Particulate Matter	$E = 4.10 * P^{0.67}$ or $E = 55 * P^{0.11} - 40$
A.10	ARM 17.8.322(4)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (liquid or solid fuels)	1 lb/MMBtu fired
A.11	ARM 17.8.322(5)	Sulfur Oxide Emissions, Sulfur in Fuel	Sulfur in Fuel (gaseous)	50 gr/100 CF
A.12	ARM 17.8.324(3)	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks	-------
A.13	ARM 17.8.324(1)	Hydrocarbon Emissions, Petroleum Products	65,000 Gallon Capacity	-------
A.14	ARM 17.8.324(2)	Hydrocarbon Emissions, Petroleum Products	Oil-effluent Water Separator	-------
A.15	40 CFR 51	State Implementation Plan (SIP)	SO_2	-------
A.16	40 CFR 51	SIP	State-Only Requirements	-------
A.17 & A.18	40 CFR 51	SIP	Sulfur Bearing Gases	-------
A.19	ARM 17.8.340	New Source Performance Standards (NSPS)	All Applicable Provisions of 40 CFR 60, Subparts Kb & GGG	-------
A.20	ARM 17.8.341	National Emission Standards for Hazardous Air Pollutants	All Applicable Provisions of 40 CFR 61, Subparts M & FF	-------
A.21	ARM 17.8.342	National Emission Standards for Hazardous Air Pollutants for Source Categories (MACT)	All Applicable Provisions of 40 CFR 63, Subpart CC	-------
A.22	40 CFR 68	Chemical Accident Prevention	Risk Management Plan	-------

A.23	ARM 17.74.336	Asbestos Abatement – Annual Permits	Asbestos	-------
A.24	ARM 17.8.749 & 17.8.801(7)	Refinery and Terminal	One Source for NSR Purposes	-------
A.25	ARM 17.8.1212	Reporting Requirements	Compliance Monitoring	-------
A.26	ARM 17.8.1207	Reporting Requirements	Annual Certifications	-------

Conditions

A.1. Pursuant to ARM 17.8.106, all emission source testing, sampling and data collection, recording analysis, and transmittal must be performed, maintained, and reported in accordance with the Montana Source Test Protocol and Procedures Manual (dated July 1994 unless superseded by rulemaking), unless alternate methods are approved by the Department.

A.2. Pursuant to ARM 17.8.304(1), ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed on or before November 23, 1968, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.3. Pursuant to ARM 17.8.304(2), ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere from any source installed after November 23, 1968, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.4. Pursuant to ARM 17.8.304(3), during the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes.

A.5. Pursuant to ARM 17.8.308(1), ExxonMobil shall not cause or authorize the production, handling, transportation, or storage of any material unless reasonable precautions to control emissions of particulate matter are taken. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.6. Pursuant to ARM 17.8.308(2), ExxonMobil shall not cause or authorize the use of any street, road or parking lot without taking reasonable precautions to control emissions of airborne particulate matter, unless otherwise specified by rule or in this permit.

A.7. Pursuant to ARM 17.8.308(3), ExxonMobil shall not operate a construction site or demolition project unless reasonable precautions are taken to control emissions of airborne particulate matter. Such emissions of airborne particulate matter from any stationary source shall not exhibit an opacity of 20% or greater averaged over 6 consecutive minutes, unless otherwise specified by rule or in this permit.

A.8. Pursuant to ARM 17.8.309, unless otherwise specified by rule or in this permit, ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment and new fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

. For new fuel-burning equipment (installed on or after November 23, 1968):

$$E = 1.026 * H^{-0.233}$$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu.

When two or more fuel-burning units are connected to a single stack, the combined heat input of all units connected to the stack shall not exceed that allowable for the same unit connected to a single stack.

A.9. Pursuant to ARM 17.8.310, unless otherwise specified by rule or in this permit, ExxonMobil shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10*P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0*P^{0.11} - 40$

Where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour.

A.10. Pursuant to ARM 17.8.322(4), ExxonMobil shall not burn liquid or solid fuels containing sulfur in excess of 1 pound per million Btu fired, unless otherwise specified by rule or in this permit. This rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million Btu fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (April 1978 Billings/Laurel Plan, that included the Board of Health and Environmental Sciences Order and the Board of Environmental Review (Board) Order signed on June 12, 1998, and subsequent revisions of March 17, 2000).

A.11. Pursuant to ARM 17.8.322(5), ExxonMobil shall not burn any gaseous fuel containing sulfur compounds in excess of 50 grains per 100 cubic feet of gaseous fuel, calculated as hydrogen sulfide at standard conditions, unless otherwise specified by rule or in this permit. This rule shall be interpreted to allow for a daily deviation of 0.1 pound of sulfur per million Btu fired. The rule shall be interpreted to allow the blending of all fuels burned in a plant during a given time period in determining the aggregate sulfur content for purposes of the rule, and it shall not be construed to require blending or physical mixing of fuels at any given furnace or heater within the plant complex (April 1978 Billings/Laurel Plan, that included the Board of Health and Environmental Sciences Order and the Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000).

A.12. Pursuant to ARM 17.8.324(3), ExxonMobil shall not load or permit the loading of gasoline into any stationary tank with a capacity of 250 gallons or more from any tank truck or trailer, except through a permanent submerged fill pipe, unless such tank is equipped with a vapor loss control device or is a pressure tank as described in ARM 17.8.324(1), or unless otherwise specified by rule or in this permit.

A.13. Pursuant to ARM 17.8.324(1), unless otherwise specified by rule or in this permit, ExxonMobil shall not place, store or hold in any stationary tank, reservoir or other container of more than a 65,000-gallon capacity any crude oil, gasoline or petroleum distillate having a vapor pressure of 2.5 pounds per square inch absolute or greater under actual storage conditions, unless such tank,

reservoir or other container is a pressure tank maintaining working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation.

A.14. Pursuant to ARM 17.8.324(2), unless otherwise specified by rule or in this permit, ExxonMobil shall not use any compartment of any single or multiple-compartment oil-effluent water separator which compartment receives effluent water containing 200 gallons a day or more of any petroleum product from any equipment processing, refining, treating, storing or handling kerosene or other petroleum product of equal or greater volatility than kerosene, unless such compartment is equipped with a vapor loss control device, constructed so as to prevent emission of hydrocarbon vapors to the atmosphere, properly installed, in good working order and in operation.

A.15. Pursuant to the June 12, 1998, Board Order and subsequent revisions of March 17, 2000, adopting a sulfur dioxide control plan (Appendix E of this permit), ExxonMobil shall comply with all requirements of Exhibit A and Attachment 1 of the plan. In addition, ExxonMobil shall comply with all terms as set forth by this permit (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; the control plan was partially approved/partially disapproved by EPA on May 2, 2002 and May 22, 2003; parts of the requirement that were disapproved remain "State Only" along with those provisions intended to be "State Only" that were not submitted to EPA).

A.16. Pursuant to the June 12, 1998, Board Order and subsequent revisions of March 17, 2000, adopting a sulfur dioxide control plan (Appendix E of this permit), ExxonMobil shall comply with all requirements of Exhibit A-1 and corresponding attachments (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

A.17. ExxonMobil shall utilize appropriate maintenance, repair, and operating practices to control emissions of sulfur bearing gases from minor sources such as ducts, stacks, valves, vents, vessels, and flanges that are not otherwise subject to the Stipulation and Exhibit A (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002).

A.18. ExxonMobil shall use good engineering judgment and appropriate engineering calculations to quantify emissions from activities that are not otherwise addressed by the Stipulation and Exhibit A but are known to contribute to emissions from sources listed in Section 1(B) of the Stipulation. In addition, ExxonMobil shall account for such emissions in determining compliance with all applicable emission limits contained in Section 3 of the Stipulation (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002).

A.19. ExxonMobil shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in the Standards of Performance for New Stationery Sources (NSPS) provisions, as appropriate, of (ARM 17.8.340):

a. 40 CFR 60, Subpart Kb 60.110b through 60.117b, Standards of Performance for Volatile Organic Liquid Storage Vessels (including Petroleum Liquid Storage Vessels for which construction, reconstruction, or modification commenced after July 23,1984) (Kb reporting will be done in accordance with 40 CFR 63, Subpart CC), and

b. 40 CFR 60, Subpart GGG, Standards of Performance for Equipment Leaks of VOCs in Petroleum Refineries.

A.20. ExxonMobil shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in the National Emission Standards for Hazardous Air Pollutants (NESHAPS) provisions, as appropriate, of 40 CFR 61, Subpart FF Benzene Waste Operations and Subpart M Asbestos. Because ExxonMobil's total annual benzene quantity, as determined pursuant to the guidance and 40 CFR 61.355, is greater than 10 mg/yr, ExxonMobil is now subject to Subpart FF, including control requirements as appropriate (ARM 17.8.341).

A.21. ExxonMobil shall comply with all applicable standards and limitations, and the reporting, recordkeeping, and notification requirements contained in the National Emission Standards for Hazardous Air Pollutants for Source Categories (MACT) provisions, as appropriate, of 40 CFR 63, Subpart CC. Where there is overlap of specific unit equipment leak requirements, such that the provisions of 40 CFR Parts 60 and 61 apply, ExxonMobil is only required to comply with the equipment leak provisions of 40 CFR 63, Subpart CC (ARM 17.8.342 and 40 CFR 63.640(p)).

A.22. A Risk Management Plan, developed in accordance with 40 CFR 68, shall be registered with the United States Environmental Protection Agency (EPA) by June 21, 1999. ExxonMobil shall submit a certification statement to the Department that states ExxonMobil is in compliance with the requirements of 40 CFR 68, including registration (40 CFR 68.160).

A.23. Pursuant to ARM 17.74.336, ExxonMobil shall comply with all the limitations and requirements of their Asbestos Abatement Annual Permit #MTF0008.

A.24. Pursuant to ARM 17.8.749 and 17.8.801(7), the ExxonMobil Refining and Supply Company and the Exxon Mobil Corporation Billings Terminal shall be considered one source for the purpose of permitting these facilities. Based on the following determinations, the facilities are considered one source:

a. The refinery and the terminal are under common ownership and control;

b. The refinery and the terminal are contiguous and adjacent; and

c. The terminal is considered a support facility to the refinery.

A.25. On or before April 15 and October 15 of each year, ExxonMobil shall submit to the Department the compliance monitoring reports required by Section V.D. These reports must contain all information required by Section V.D, as well as the information required by each individual emission unit. For the reports due by October 15 of each year, ExxonMobil may submit a single report provided that it contains all the information required by Section V.B and V.D. Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including semiannual monitoring reports), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that,* ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

A.26. By October 15 of each year, ExxonMobil shall submit to the Department the compliance certification report required by Section V.B. The annual certification report required by Section V.B must include a statement of compliance based on the information available that identifies any observed, documented or otherwise known instance of noncompliance for each applicable requirement Per ARM 17.8.1207,

> *any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12 (including annual certifications), shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that,* ***"based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete."***

B. Refinery Offset, Refinery-wide Sulfur-in-Fuel, Refinery Fuel Gas, and Fuel Oil Consumption (multiple emitting unit) Limitations

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
B.1, B.6, B.12, B.17	Refinery-wide Sulfur-in-Fuel	0.96 lb/MMBtu	Methods outlined in September 25, 1989 letter	Ongoing	Semiannually
B.2, B.7, B.13, B.17	Coker Process Gas	Send Coker Process Gas to YELP	Recordkeeping	Whenever YELP Operates	Semiannually
B.3, B.8, B.9, B.10, B.14, B.15, B.16, B.17	SO_2 Refinery Fuel Gas Units	92.4 lb/3-hour period 739.2 lb/day	SO_2/H_2S CEMS, Flow Rate Monitor	Ongoing	Quarterly
			Method 11	Annually	Semiannually
B.4, B.8, B.9, B.10, B.14, B.15, B.16, B.17	SO_2 Refinery Fuel Gas Units	76.2 lb/3-hour period 609.6 lb/day	SO_2/H_2S CEMS, Flow Rate Monitor	Ongoing	Quarterly
			Method 11	Annually	Semiannually
B.5, B.11, B.13, B.17	Refinery Wide Fuel Oil Consumption	41.7 kbarrels/rolling 12 months	Recordkeeping	Ongoing	Semiannually

Conditions

B.1. A refinery-wide block hourly limit of 0.96 lb of sulfur in fuel per million British Thermal Units (MMBtu) fired shall be adhered to at all times. In the event ExxonMobil fails to meet the hourly limit of 0.96 lb of sulfur per MMBtu fired, ExxonMobil shall immediately notify YELP of this occurrence. After such an occurrence, ExxonMobil shall also provide subsequent notification to YELP when it has met the hourly sulfur-in-fuel limitation for 3-consecutive hourly periods (ARM 17.8.749).

B.2. ExxonMobil shall, any time the YELP facility is operating, send all of its Coker process gas to either or both of YELP's boilers. During start-up and shutdown conditions at YELP, ExxonMobil shall supply the maximum amount of Coker process gas that YELP can accept (ARM 17.8.749).

B.3. The following emission limitations shall apply whenever YELP is receiving ExxonMobil Coker unit flue gas or whenever the ExxonMobil Coker unit is not operating. Refinery fuel gas combustion from the following units: Coker CO Boiler, FCC CO Boiler, F-2 Crude/Vacuum

Heater, F-3 unit, F-3X unit, F-5 unit, F-700 unit, F-201 unit, F-202 unit, F-402 unit, F-551 unit, F-651 unit, the standby boiler house (B-8 boiler), and F-1201 unit (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003):

a. Combined 3-hour emissions of SO_2 from the refinery fuel gas combustion units shall not exceed 92.4 pounds per 3-hour period, and

b. Combined daily emissions of SO_2 from the refinery fuel gas combustion units shall not exceed 739.2 pounds per calendar day.

B.4. The following emission limitations shall apply whenever YELP is not receiving ExxonMobil Coker unit flue gas and the ExxonMobil Coker unit is operating. Refinery fuel gas combustion from the following units: FCC CO Boiler, F-2 Crude/Vacuum Heater, F-3 unit, F-3X unit, F-5 unit, F-700 unit, F-201 unit, F-402 unit, F-551 unit, F-651 unit, the standby boiler house (B-8 boiler), and F-1201 unit (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003):

a. Combined 3 hour emissions of SO_2 from the refinery fuel gas combustion units shall not exceed 76.2 pounds per 3 hour period, and

b. Combined daily emissions of SO_2 from the refinery fuel gas combustion units shall not exceed 609.6 pounds per calendar day.

B.5. Refinery-wide fuel oil consumption by all consumption units (i.e., boilers, furnaces, etc.) shall not exceed 41.7 kbarrels during any rolling 12-month period (ARM 17.8.749).

Compliance Demonstration

B.6. Compliance with this sulfur-in-fuel limit shall be monitored according to the techniques outlined in ExxonMobil's letter dated September 25, 1989, (Appendix F), as adjusted to measure the sulfur-in-fuel limit on an hourly basis. For determining the sulfur weight percent, ExxonMobil may also use ASTM Method D2622 or another method as may be approved by the Department (ARM 17.8.749).

B.7. Any time ExxonMobil diverts process Coker gases from YELP, ExxonMobil shall report said diversion to the Department within 24 hours or during the next regular working day. This information shall also be included in the quarterly CEMS sulfur-in-fuel report and include the period(s) of diversion, quantity of sulfur oxide emissions, reason for the diversion(s), and corrective measures taken to prevent reoccurrence (ARM 17.8.749).

B.8. In accordance with the Stipulation (Appendix E of this permit), ExxonMobil shall operate and maintain hydrogen sulfide (H_2S) concentration monitoring at the refinery fuel gas header. Compliance with the combined SO_2 emission limitation for the fuel gas combustion units contained in Sections III.B.3 and III.B.4 of this permit shall be monitored by using hourly-average H_2S concentrations and hourly-average fuel gas-firing rates from the CEMS required by Exhibit A, Section 6(B)(3) and (8) of the Stipulation and in accordance with the appropriate equation(s) in Exhibit A, Section 2(A)(1), (8), (11), and (16) of the Stipulation except when CEMS data is not available as provided in Exhibit A, Section 2(A)(16) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

B.9. In order to monitor the H_2S concentration in parts per million for the fuel gas system, ExxonMobil shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Method 11) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

B.10. In accordance with the Stipulation, ExxonMobil shall operate and maintain a continuous flow rate monitor on the refinery fuel gas header. Accuracy determinations for the refinery fuel flow rate monitor shall be required at least once every 48 months or more frequently as routine refinery turn-arounds allow (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

B.11. ExxonMobil shall document, by month, facility-wide fuel oil combustion. By the 25th day of each month, ExxonMobil shall total the amount of facility-wide fuel oil combustion during the previous 12 months to monitor compliance with the limitation in Section III.B.5 (ARM 17.8.749).

Recordkeeping

B.12 ExxonMobil shall maintain records of the sulfur-in-fuel values based on the techniques described in Section III.B.6 or, if a CEM is used (as required by Section III.B.8) as an approved alternative, recordkeeping shall be required according to Section III.B.14 (ARM 17.8.1212).

B.13. ExxonMobil shall keep records as required in this permit to monitor compliance with Sections III.B.2 and III.B.5 (ARM 17.8.1212).

B.14. In accordance with the Stipulation, ExxonMobil shall record, organize, report, and archive all the data specified in Section 7(C) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

Reporting

B.15. In accordance with Section 7 of the Stipulation (Appendix E of this permit), ExxonMobil shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

B.16. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

B.17. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. Verification that the sulfur-in-fuel limit was complied with and the appropriate records were kept;

b. Verification that the information described by Section III.B.7 was reported as required and that the appropriate records were kept;

c. Verification that the H_2S concentration monitoring and continuous flow rate monitor at the refinery fuel gas header was operated and maintained as required by the Stipulation;

d. A summary of the results of any required reference method tests performed during the reporting period;

e. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation; and

f. Verification of compliance with the fuel-oil combustion limit.

C. EU01 – Crude – APS and VPS

EU01a: F-2 Crude Vacuum Heater Stack (F-1 Crude Furnace/F-401 Vacuum Heater)
EU01b: F-3 Heater Stack
EU01c: D-4 Drum Atmospheric Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
C.1, C.8, C.15, C.20, C.21	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
C.2, C.9, C.21	H_2S	------	Steam Injection	As necessary	Semiannually
C.3, C.10, C.15, C.20, C.21	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
C.4, C.5, C.11, C.12, C.16, C.19, C.21	SO_2 F-2 Crude/Vacuum Heater Stack	271.4 lb/3-Hr 2,171.2 lb/day	H_2S CEMS, SWS CEMS, & Sampling	Ongoing	Quarterly
C.6, C.13, C.17, C.19, C.21	Burning SWSOH in F-1 Crude Furnace or the Flare	Electronic Sensor on Valve Supplying SWSOH	Operate Sensor on the Valve and Perform Recordkeeping	Whenever Valve is Opened	Semiannually
C.7, C.14, C.18, C.21	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

C.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-2 Crude Vacuum Heater stack, the F-3 Heater Stack, and the D-4 Drum Atmospheric stack, that exhibit opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

C.2. The D-4 Drum Atmospheric Vent Stack shall have steam injection capability and shall be used whenever H_2S is being released or is expected to be released from a process unit to the D-4 Drum (ARM 17.8.749).

C.3. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equation:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309(2)). When two or more fuel-burning units are connected to a single stack, the combined heat input of all units connected to the stack shall not exceed that allowable for the same unit connected to a single stack (ARM 17.8.309(3)).

C.4. The following emission limitations shall apply to the F-2 Crude/Vacuum Heater Stack whenever YELP is receiving ExxonMobil Coker unit flue gas or whenever the ExxonMobil Coker unit is not operating (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

a. SO_2 3-hour emissions from the F-2 Crude/Vacuum Heater Stack shall not exceed 271.4 pounds per 3-hour period, and

b. Daily emissions of SO_2 from the F-2 Crude/Vacuum Heater Stack shall not exceed 2,171.2 pounds per calendar day.

C.5. The following emission limitations shall apply to the F-2 Crude/Vacuum Heater Stack whenever YELP is not receiving ExxonMobil Coker unit flue gas and the ExxonMobil Coker unit is operating (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002).

a. SO_2 3-hour emissions from the F-2 Crude/Vacuum Heater Stack shall not exceed 271.4 pounds per 3-hour period, and

b. Daily emissions of SO_2 from the F-2 Crude/Vacuum Heater Stack shall not exceed 2,171.2 pounds per calendar day.

C.6. ExxonMobil shall burn the sour water stripper overheads in the FCC CO Boiler and exhaust those emissions through the FCC CO Boiler stack, except that the sour water stripper overheads may be burned in the F-1 Crude Furnace (and exhausted through the F-2 Crude/Vacuum Heater stack) or in the flare during periods when the FCC CO Boiler is unable to burn the sour water stripper overheads, provided that:

a. Such periods do not exceed 55 days per calendar year and 65 days for any 2 consecutive calendar years, and

b. During such periods, the sour water stripper system is operating in a two-tower configuration.

(Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only")

C.7. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

C.8. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

C.9. ExxonMobil shall provide comment and explanation whenever the steam injection capability did not operate during periods when H_2S was being released or was expected to be released from a process unit to the D-4 Drum (ARM 17.8.1213).

C.10. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

C.11. In accordance with the Stipulation (Appendix E of this permit), ExxonMobil shall operate and maintain a continuous flow rate monitor to determine the sour water flow rate to the T-23 stripper tower. Accuracy determinations for the sour water flow rate monitor shall be required at least once every 48 months and within three months prior to any scheduled shutdown of the FCC CO Boiler and shall be conducted in accordance with Attachment #2 of the Stipulation (or another method approved by the Department and EPA) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.12. Whenever sour water stripper overheads are being burned in the F-1 Crude (and exhausted through the F-2 Crude/Vacuum Heater stack) Furnace or in the flare, compliance with the emission limitations contained in Section III.C.4 and 5 of this permit shall be monitored using flow rate monitoring data required by Exhibit A, Section 6(B)(9) of the Stipulation (Appendix E of this permit or Section III.C.13) and from sampling and analysis of the sour water feed to the T-23 sour water stripper tower. Except for the first 2 hours after sour water stripper overheads are directed to the F-1 Crude Furnace, ExxonMobil shall collect at least one sample from the sour water feed to the T-23 sour water stripper tower for each of the eight non-overlapping 3-hour periods in a calendar day. In addition, the time elapsed before collection of the first sample shall not exceed 4 hours. ExxonMobil shall analyze the sample for H_2S in accordance with the procedures contained in Attachment #2 of the Stipulation (or another method approved by the Department and EPA), and ExxonMobil shall use the results to calculate the hourly SO_2 emission rate for each of the hours in the 3-hour period in accordance with the equations in Exhibit A, Section 2 (A) (1), (8), (11), and (16) of the Stipulation (Appendix F of this permit). Notwithstanding the fact that fuel gas combustion emissions from the F-2 Crude/Vacuum Heater are measured by the fuel gas system CEMS and counted against the emission limitations contained in Section 3 (A)(1) and (B)(2) of the Stipulation (Appendix E of this permit), such emission are also counted against the emission limitations contained in Section 3 (A)(2) and (B)(3) of the Stipulation (Appendix E of this permit) if for any reason source testing is conducted on the F-2 Crude/Vacuum Heater stack (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.13. ExxonMobil shall operate an electronic sensor on the valve, which supplies sour water stripper overheads to the F-1 Crude Furnace and/or the flare. The electronic sensor shall be electronically integrated with the Data Acquisition System (DAS) to insure that each time the valve is opened (sour water stripper overheads to the F-1 Crude Furnace or the flare) the DAS automatically records the date and time that the valve is opened and the length of time the SWSOH are directed to the F-1 Crude Furnace or the flare (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.14. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

C.15. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

C.16. In accordance with the Stipulation, ExxonMobil shall record, organize, report, and archive all the data specified in Section 7(C) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.17. Whenever the valve, which supplies sour water stripper overheads to the F-1 Crude Furnace, is opened, ExxonMobil shall log the date and time and the reasons for such action (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.18. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

C.19. In accordance with Section 7 of the Stipulation (Appendix E of this permit), ExxonMobil shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

C.20. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 7.8.106).

C.21. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification that the D-4 Drum Atmospheric Vent stack steam injection was operational and used as specified by Section III.C.9;

c. Verification that the sampling was conducted in accordance with the Stipulation whenever sour water stripper overheads were burned in the F-1 Crude Furnace and exhausted through the F-2 Crude/Vacuum Heater stack;

d. Verification that the electronic sensor on the valve that supplies sour water stripper overheads to the F-1 Crude Furnace was operational and that records were kept as specified by Section III.C.17;

e. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation; and

f. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

D. EU02 – HF #2/3 – Hydrofining Units #2 & #3

EU02a: F-3X Heater Stack
EU02b: F-5 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
D.1, D.5, D.8, D.10, D.11	Opacity F-3X Heater Stack	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
D.2, D.5, D.8, D.10, D.11	Opacity F-5 Heater Stack	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
D.3, D.6, D.8, D.10, D.11	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$ Or $E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department	Semiannually
D.4, D.7, D.9, D.11	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

D.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-3X Heater, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

D.2. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-5 Heater, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

D.3. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment and new fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$ (F-3X Heater)

For new fuel-burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$ (F-5 Heater)

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

D.4. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

D.5. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section II.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

D.6. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

D.7. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

D.8. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

D.9. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

D.10. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

D.11. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

E. EU03 – Coker – Fluid Coker

EU03a: KCOB – Coker CO Boiler Stack
EU03b: F-202 – Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
E.1, E.10, E.19, E.26, E.27	Opacity F-202 Heater Stack	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
E.2, E.11, E.19, E.26, E.27	Opacity KCOB Coker CO Boiler Stack	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
			COMS	Ongoing	Quarterly
E.3, E.12, E.19, E.26, E.27	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$ or $E = 1.026 * H^{-0.233}$	Method 5	1 in 5 yrs When YELP is Down	Semiannually

E.4, E.12, E.19, E.26, E.27	Particulate Matter Process Weight KCOB Coker CO Boiler Stack	$E = 4.10 * P^{0.67}$ or $E = 55.0 * P^{0.11} - 40$	Method 5	1 in 5 yrs When YELP is Down	Semiannually
E.5, E.13, E.20, E.24, E.27	COMS	Operate and maintain COMS	40 CFR 51, Appendix P and 40 CFR Part 60, Appendix B, Specification 1	Ongoing	Quarterly
E.6, E.14, E.15, E.16, E.21, E.25, E.26, E.27	SO_2 Coker CO Boiler Stack	2,142.9 lb/3-Hr 17,143.1 lb/day	Install, Operate, and Maintain SO_2 CEMS (or Approved Alternative)	Ongoing	Quarterly
			Methods 1-4 & 6/6C	As Required by the Stipulation	Semiannually
E.7, E14, E.15, E.16, E.21, E.25, E.26, E.27	Exhausting Coker Unit Flue Gas Through the Coker CO Boiler Stack	>336 Hr/Quarter	Install, Operate, and Maintain SO_2 CEMS (or Approved Alternative)	Ongoing	Quarterly
			Methods 1-4 & 6/6C	As Required by the Stipulation	Semiannually
E.8, E.17, E.22, E.27	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654
E.9, E.18, E.23, E.27	Misc. Process Vents	As Required by 40 CFR 63.643	Monitoring and Testing	As Required by 40 CFR 63.644 & 645	As Required by 40 CFR 63.644 & 645

Conditions

E.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-202 Heater Stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

E.2. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the KCOB Coker CO Boiler Stack, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

E.3. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment and new fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$ (F-202 Heater Stack)

For new fuel-burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$ (KCOB Coker CO Boiler Stack)

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309(2)). When two or more fuel-burning units are connected to a single stack, the combined heat input of all units connected to the stack shall not exceed that allowable for the same unit connected to a single stack (ARM 17.8.309(3)).

E.4. ExxonMobil shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10 * P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0 * P^{0.11} - 40$

Where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

E.5. ExxonMobil shall operate and maintain an opacity continuous emission monitor (continuous opacity monitoring system (COMS)) on the Coker CO Boiler stack (Administrative Order signed on June 27, 1990; this requirement is "State Only").

E.6. The following emission limitations shall apply to the Coker CO Boiler stack (includes process exhaust gases and F-202 Heater fuel gas-firing emissions) whenever YELP is not receiving ExxonMobil Coker unit flue gas and the ExxonMobil Coker unit is operating (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

a. SO_2 3-hour emissions from the Coker CO Boiler stack shall not exceed 2,142.9 pounds per 3-hour period, and

b. Daily emissions of SO_2 from the Coker CO Boiler stack shall not exceed 17,143.1 pounds per calendar day.

E.7. In accordance with Section 6(4) and (5) of the Stipulation, after January 1, 1998, if ExxonMobil exhausts Coker unit flue gas through the Coker CO Boiler stack more than 336 hours in a calendar quarter, ExxonMobil shall, within 180 days after the end of the calendar quarter:

a. Install and certify, in accordance with 40 CFR Part 60, Appendix B and Method A-1 of Attachment #1 of the Stipulation, a portable continuous sulfur dioxide concentration monitor and a portable continuous stack flow rate monitor on the Coker CO Boiler stack; or

b. Implement a CEMS-Equivalent Alternative Monitoring Plan that has been approved by the Department and EPA.

(Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003)

E.8. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

E.9. ExxonMobil shall comply with the miscellaneous process vent provisions in 40 CFR 63.643 as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

E.10. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

E.11. As required by the Department, a Method 9 test must be performed in accordance with Section III.A.1. ExxonMobil shall also monitor compliance with the opacity limitation using the data from the COMS and other Department approved sampling methods (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

E.12. Once every 5 years (within the permit term), when YELP is not operating, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

E.13. Opacity monitoring, COMS operation and maintenance, and reporting shall be performed by ExxonMobil consistent with the requirements of both 40 CFR 51, Appendix P and 40 CFR Part 60, Appendix B, Performance Specification 1 (Administrative Order signed on June 27, 1990; this requirement is "State Only").

E.14. If a CEMS, or CEMS-Equivalent Alternative Monitoring Plan approved by the Department and EPA, is required, compliance shall be determined using data from the:

a. CEMS and in accordance with the appropriate equation(s) in Section 2(A)(1), (8), (11), and (16) of the Stipulation except when CEMS data is not available as provided in Section 2(A)(16) of the Stipulation; or

b. CEMS-Equivalent Alternative Monitoring Plan approved by the Department and EPA and in accordance with the equations in Section 2(A)(1), (8), and (16) of the Stipulation.

(Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

E.15. In order to certify the SO_2 emission rates in pounds per hour for the Coker CO Boiler stack (if a CEMS or CEMS-Equivalent Alternative Monitoring Plan is required to be installed by Section 6(B)(4) of the Stipulation (Appendix E of this permit)), ExxonMobil shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c as appropriate for this Stipulation and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106). The annual Relative Accuracy Test Audits (RATAs) required by Sections 6(C and D) of the Stipulation, may substitute for the annual source tests provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of SO_2 (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

E.16. After installation and certification of the portable monitors (unless ExxonMobil chooses to implement a CEMS-Equivalent Alternative Monitoring Plan) required by Section 6(B)(4)(a) of the Stipulation, ExxonMobil may remove the monitors from the Coker CO Boiler stack whenever Coker unit flue gas is not being exhausted through the stack. However, at any time after initial installation and certification of the monitors ExxonMobil exhausts Coker unit flue gas through the Coker CO Boiler stack, ExxonMobil shall within 48 hours:

a. Reinstall the portable monitors at the same location on the Coker CO Boiler stack (including probe position in the stack);

b. Perform a cylinder gas audit (CGA) or Relative Accuracy Audit (RAA) which meets the requirements and specifications of 40 CFR Part 60, Appendix F; and

c. Operate the monitors in accordance with the quality assurance requirements of Section 6 as long as Coker unit flue gas continues to be exhausted through the Coker CO Boiler stack.

(Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

E.17. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

E.18. ExxonMobil shall monitor compliance with the miscellaneous process vent provisions by performing the monitoring and testing specified in 40 CFR 63.444 and 445 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

E.19. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1. ExxonMobil shall maintain COM data and submit the reports to the Department quarterly (ARM 17.8.106 and ARM 17.8.1212).

E.20. Recordkeeping associated with the COMS shall be performed consistently with the requirements of both 40 CFR 51, Appendix P and 40 CFR Part 60, Appendix B, Performance Specification 1 (Administrative Order signed on June 27, 1990; this requirement is "State Only").

E.21. In accordance with the Stipulation, ExxonMobil shall record, organize, report, and archive all the data specified in Section 7(C) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

E.22. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

E.23. ExxonMobil shall comply with the reporting and recordkeeping requirements for miscellaneous process vent provisions in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

E.24. ExxonMobil shall report to the Department, on a calendar quarterly basis, opacity results from the COMS, which exceed the 20% provided in ARM 17.8.304 (2) (Administrative Order signed on June 27, 1990; this requirement is "State Only").

E.25. In accordance with Section 7 of the Stipulation (Appendix E of this permit), ExxonMobil shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the

Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report. The quarterly reports shall also include the report on the COM for the Coker CO Boiler stack (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

E.26. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

E.27. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. A summary of the hours that ExxonMobil exhausted the Coker Unit flue gas through the Coker CO Boiler stack;

c. A statement of what compliance demonstration method was used to verify compliance with the emission limits in Section III.E.6 and whether ExxonMobil performed the compliance demonstration method as specified by the Stipulation;

d. Verification that COMS quarterly reports were submitted to the Department as required by the June 1990 Administrative Order;

e. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation;

f. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC; and

g. Certification of compliance with the miscellaneous process vent provisions monitoring, testing, reporting, and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

F. EU04 – POFO – Powerforming Unit

EU04a: F-700 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
F.1, F.8, F.15, F.19, F.20	Opacity	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
F.2, F.9, F.15, F.19, F.20	Particulate Matter Fuel-Burning Equipment	$E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department	Semiannually
F.3, F.10, F.15, F.19, F.20	NO_x	Ultra Low NO_x Burners	Method 7	Every 5 years	Semiannually
		9.73 lb/hr			

F.4, F.11, F.15, F.19, F.20	CO	9.58 lb/hr	Method 10	As Required by the Department	Semiannually
F.5, F.12, F.16, F.20	RFG/Natural gas Consumption	995 MMscf/ rolling 12 months	Recordkeeping	Monthly	Semiannually
F.6, F.13, F.17, F.20	H_2S in RFG	160 ppm_v, 40 CFR 60, Subpart J	40 CFR 60, Subpart J	40 CFR 60, Subpart J	Semiannually
F.7, F.14, F.18, F.20	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

F.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-700 Heater stack, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

F.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for new fuel-burning equipment calculated using the following equations:

For new fuel-burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

F.3 Ultra Low NO_X Burners (ULNBs) shall be used in the modified furnace F-700 to control NO_X emissions. The NO_X emissions shall not exceed 9.73 lb/hr (ARM 17.8.752). [This condition is not applicable until F-700 is modified.]

F.4. The CO emissions from the modified furnace F-700 shall not exceed 9.58 lb/hr (ARM 17.8.749). [This condition is not applicable until F-700 is modified.]

F.5. The modified furnace F-700 shall not consume more than 995 MMscf of RFG and natural gas combined during any rolling 12-month period (ARM 17.8.749). [This condition is not applicable until F-700 is modified.]

F.6. The RFG used in F-700 shall not exceed 160 ppm_v (230 mg/dscm or 0.1 grains/dscf) of H_2S (ARM 17.8.340 and 40 CFR 60, Subpart J). [This condition is not applicable until F-700 is modified.]

F.7. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.341; and 40 CFR 61, Subparts J and V).

Compliance Demonstration

F.8. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

F.9. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

F.10. ExxonMobil shall perform a Method 7 test in accordance with Section III.A.1 every 5 years after the initial source test or according to another testing/monitoring schedule as may be approved by the Department, to monitor compliance with the NO_X limitations for furnace F-700 found in Section III.F.3 (ARM 17.8.106 and ARM 17.8.749). [This condition is not applicable until F-700 is modified.]

F.11. As required by the Department, ExxonMobil shall perform a Method 10 test in accordance with Section III.A.1, to monitor compliance with the CO limitations for furnace F-700 found in Section III.F.4 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.749). [This condition is not applicable until F-700 is modified.]

F.12. ExxonMobil shall document, by month, the total amount of RFG/natural gas consumed by furnace F-700. By the 25th of each month, ExxonMobil shall total the amount of RFG/natural gas consumed by furnace F-700 during the previous 12 months to monitor compliance with the limitation in Section III.F.5 (ARM 17.8.749). [This condition is not applicable until F-700 is modified.]

F.13. ExxonMobil shall perform compliance monitoring in accordance with 40 CFR 60, Subpart J to monitor compliance with the requirements of 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J). [This condition is not applicable until F-700 is modified.]

F.14. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.341; and 40 CFR 61, Subparts J and V).

Recordkeeping

F.15. All source testing recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).

F.16. ExxonMobil shall keep records as required in this permit according to Section III.F.12 (ARM 17.8.1212). [This condition is not applicable until F-700 is modified.]

F.17. Recordkeeping shall be performed in accordance with 40 CFR 60, Subpart J for the applicable requirements as they apply to furnace F-700 (ARM 17.8.340 and 40 CFR 60, Subpart J). [This condition is not applicable until F-700 is modified.]

F.18. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342; 40 CFR 63, Subpart CC; ARM 17.8.341; and 40 CFR 61, Subparts J and V).

Reporting

F.19. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

F.20. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification that the total amount of RFG/natural gas consumed by furnace F-700 was recorded on a monthly basis [This condition is not applicable until F-700 is modified.];

c. Certification that compliance with the reporting and recordkeeping requirements of 40 CFR 60, Subpart J were maintained [This condition is not applicable until F-700 is modified.]; and

d. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC (40 CFR 61, Subparts J and V).

G. EU05 – Alky/Splitter/Rerun/Diene – Alkylation Unit, Alky Feed Treater, Rerun of Alkylate for Avgas and Gasoline

EU05a: F-402 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
G.1, G.4, G.7, G.9, G.10	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
G.2, G.5, G.7, G.9, G.10	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
G.3, G.6, G.8, G.10	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

G.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-402 Heater stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

G.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

G.3. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

G.4. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

G.5. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

G.6. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

G.7. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

G.8. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

G.9. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

G.10. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

H. EU06 –Treater – Cat Naphtha Caustic Treater (Merox Unit) after Cat Cracker

Group 2 Storage Vessels: #5, #7, #15, #16, #17, #19, #410

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
H.1, H.3, H.5, H.7, H.8	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
H.2, H.4, H.6, H.8	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

H.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the Treater, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

H.2. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

H.3. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

H.4. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

H.5. Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

H.6. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

H.7. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

H.8. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

I. EU07 – HF#1

EU07a: F-201 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
I.1, I.4, I.7, I.9, I.10	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually

I.2, I.5, I.7, I.9, I.10	Particulate Matter Fuel-Burning Equipment	$E = 0.882*H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
I.3, I.6, I.8, I.10	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

I.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-201 Heater stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

I.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

I.3. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

I.4. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

I.5. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

I.6. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

I.7. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

I.8. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

I.9. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

I.10. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

J. EU08 – DEC2 – Deethanizer Unit

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
J.1, J.2, J.3, J.4, J.5	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually

Conditions

J.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the Deethanizer, that exhibit opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

Compliance Demonstration

J.2. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

Recordkeeping

J.3. Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

Reporting

J.4. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

J.5. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide a summary of the results of any required reference method tests performed during the reporting period (ARM 17.8.1212).

K. EU09 – FCCU – Cat Cracking Unit

EU09a: CCOB Stack - FCC CO Boiler Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
K.1, K.9, K.15, K.18, K.19, K.20	Opacity	40%/60% for Soot Blowing	Method 9	As required by the Department	Semiannually
			COMS	Ongoing	Quarterly
K.2, K.10, K.15, K.19, K.20	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	Every 2 Yrs	Semiannually
K.3, K.10, K.15, K.19, K.20	Particulate Matter – Process Weight	$E = 4.10 * P^{0.67}$ Or $E = 55.0 * P^{0.11} - 40$	Method 5	Every 2 Yrs	Semiannually
K.4.a, K.6, K.11, K.12, K.13, K.16, K.18, K.19, K.20	SO_2 -- ExxonMobil Coker Process Gas going to YELP and FCC CO Boiler Stack	For No. lb/3-hr See K.4 Table 1a	SO_2 CEMS	Ongoing	Quarterly
			Method6/6C	Annually	Semiannually
K.4.b, K.6, K.11, K.12, K.13, K.16, K.18, K.19, K.20	SO_2 -- ExxonMobil Coker Process Gas going to YELP and FCC CO Boiler Stack	For No. lb/day See K. K.4 Table 1b	SO_2 CEMS	Ongoing	Quarterly
			Method6/6C	Annually	Semiannually
K.5.a, K.6, K.11, K.12, K.13, K.16, K.18, K.19, K.20	SO_2 – ExxonMobil Coker Process Gas not going to YELP and FCC CO Boiler Stack	For No. lb/3-hr See K.5 Table 2a	SO_2 CEMS	Ongoing	Quarterly
			Method6/6C	Annually	Semiannually
K.5.b, K.6, K.11, K.12, K.13, K.16, K.18, K.19, K.20	SO_2 -- ExxonMobil Coker Process Gas not going to YELP and FCC CO Boiler Stack	For No. lb/day See K.5 Table 2b	SO_2 CEMS	Ongoing	Quarterly
			Method6/6C	Annually	Semiannually
K.7, K.12, K.13, K.16, K.18, K.20	Sour Water Stripper Overheads	Burning the Sour Water Stripper Overheads in the FCC CO Boiler or the Flare	CEMS	Ongoing	Quarterly
K.8, K.14, K.17, K.20	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

K.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the FCC CO Boiler stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)). ExxonMobil shall continuously operate and maintain the COM on the CCOB Stack – FCC CO Boiler stack (ARM 17.8.103(d) and 40 CFR 51, Appendix P).

K.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309(2)). When two or more fuel-burning units are connected to a single stack, the combined heat input of all units connected to the stack shall not exceed that allowable for the same unit connected to a single stack (ARM 17.8.309(3)).

K.3. ExxonMobil shall not cause or authorize particulate matter to be discharged from any operation, process, or activity into the outdoor atmosphere in excess of the maximum hourly allowable emissions of particulate matter calculated using the following equations:

For process weight rates up to 30 tons per hour: $E = 4.10 * P^{0.67}$
For process weight rates in excess of 30 tons per hour: $E = 55.0 * P^{0.11} - 40$

Where E is the rate of emissions in pounds per hour and P is the process weight rate in tons per hour (ARM 17.8.310).

K.4. The following emission limitations shall apply to the FCC CO Boiler stack whenever YELP is receiving ExxonMobil Coker unit flue gas or whenever the ExxonMobil Coker unit is not operating (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

a. SO_2 3-hour emissions from the FCC CO Boiler stack shall not exceed those values set forth in the following Table 1a. The 3-hour SO_2 emission limitations from the FCC CO Boiler stack shall be determined by the 3-hour average FCC fresh feed rate, expressed in thousands of barrels per day (kBD), rounded up to the nearest whole barrel.

Table 1a

3-Hour Average FCC Fresh Feed Rate (kBD)	3-Hour SO_2 Emission Limit (lb of SO_2 per 3-hours)
less than 12.999	5886.8
13.000 to 13.999	6052.0
14.000 to 14.999	6103.7
15.000 to 15.999	6130.6
16.000 to 16.999	6221.8
Greater than 17.000	6280.4

b. Daily emissions of SO_2 from the FCC CO Boiler stack shall not exceed those values set forth in the following Table 1b. The daily SO_2 emission limitations from the FCC CO Boiler stack shall be determined by the daily average FCC fresh feed rate, expressed in thousands of barrels per day (kBD), rounded up to the nearest whole barrel.

Table 1b

Daily Average FCC Fresh Feed Rate (kBD)	Daily SO_2 Emission Limit (lb of SO_2 per Calendar Day)
less than 12.999	47,094.3
13.000 to 13.999	48,416.3
14.000 to 14.999	48,829.7
15.000 to 15.999	49,044.9
16.000 to 16.999	49,774.5
greater than 17.000	50,243.1

K.5. The following emission limitations shall apply to FCC CO Boiler stack whenever YELP is not receiving ExxonMobil Coker unit flue gas and the ExxonMobil Coker unit is operating (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

a. SO_2 3-hour emissions from the FCC CO Boiler stack shall not exceed those values set forth in the following Table 2a. The 3-hour SO_2 emission limitations from the FCC CO Boiler stack shall be determined by the 3-hour average FCC fresh feed rate expressed in thousands of barrels per day (kBD), rounded up to the nearest whole barrel.

Table 2a

3-Hour Average FCC Fresh Feed Rate (kBD)	3-Hour SO_2 Emission Limit (lb of SO_2 per 3-hours)
less than 12.999	5231.5
13.000 to 13.999	5485.3
14.000 to 14.999	5743.7
15.000 to 15.999	5966.6
16.000 to 16.999	6190.4
Greater than 17.000	6416.4

b. Daily Emissions of SO_2 from the FCC CO Boiler stack shall not exceed those values set forth in the following Table 2b. The daily SO_2 emission limitations from the FCC CO Boiler stack shall be determined by the daily average FCC fresh feed rate expressed in thousands of barrels per day (kBD), rounded up to the nearest whole barrel

Table 2b

Daily Average FCC Fresh Feed Rate (kBD)	Daily SO_2 Emission Limit (lb of SO_2 per Calendar Day)
less than 12.999	41,852.1
13.000 to 13.999	43,882.7
14.000 to 14.999	45,949.5
15.000 to 15.999	47,732.5
16.000 to 16.999	49,523.1
greater than 17.000	51,330.8

K.6. If continuous flow rate meter data (used to determine the FCC fresh feed rate) is unavailable, the emission limitation shall be determined using a substitute hourly average fresh feed rate determined in accordance with the requirements of Section 2(A)(15) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.7. ExxonMobil shall burn the sour water stripper overheads in the FCC CO Boiler and exhaust those emissions through the FCC CO Boiler stack, except that the sour water stripper overheads may be burned in the F-1 Crude Furnace (and exhausted through the F-2 Crude/Vacuum Heater stack) or in the Flare during periods when the FCC CO Boiler is unable to burn the sour water stripper overheads, provided that:

a. Such periods do not exceed 55 days per calendar year and 65 days for any 2 consecutive calendar years, and

b. During such periods the sour water stripper system is operating in a two-tower configuration.

(Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only")

K.8. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

K.9. As required by the Department, a Method 9 test must be performed in accordance with Section III.A.1. ExxonMobil shall also monitor compliance with the opacity limitation using the data from the COM and other Department approved sampling methods (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

K.10. Every 2 years from the issuance of this permit, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

K.11. In accordance with the Stipulation (Appendix E of this permit), ExxonMobil shall operate and maintain a continuous flow rate meter to determine the fresh feed rate to the FCC reactor. In addition, ExxonMobil shall maintain a spare parts inventory (at a minimum, a spare transducer) that together with the FCC-specific Programmable Logic Controller (PLC) module is capable of functioning as a back-up continuous flow rate meter to measure the fresh feed rate to the FCC reactor. The back-up continuous flow rate meter shall be a completely redundant system capable of obtaining flow rate data in the event of the failure of the primary continuous flow rate meter required by this section. However, the back-up system may rely upon the in-pipe orifice plate and associated mechanical connections that are components of the primary continuous flow rate meter up to, but not including, the transducer. Accuracy determinations for the FCC Fresh Feed Rate Meter shall be required at least once every 48 months or more frequently as routine refinery turn-arounds allow (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.12. In accordance with the Stipulation (Appendix E of this permit), ExxonMobil shall operate and maintain a continuous emission monitor to measure sulfur dioxide concentrations from the FCC CO Boiler stack and shall operate and maintain a continuous stack flow rate monitor to measure stack gas flow rates from the FCC CO Boiler stack. Compliance with the emission limitations contained in Section III.K.4 and K.5 shall be monitored using data from the CEMS required by

Section 6(B)(1) and (2) of the Stipulation (Appendix E of this permit) and in accordance with the appropriate equation(s) in Section 2(A)(1), (8), (11), and (16) of the Stipulation, except when CEMS data is not available as provided in Section 2(A)(16) of the Stipulation. Although the CEMS data is the method of demonstrating compliance on a continuous basis, the data from the testing required by Section 5(A) or Section 6(C and D) of the Stipulation shall also be used to demonstrate compliance. Notwithstanding the fact that fuel gas combustion emissions from the FCC CO Boiler are measured by the fuel gas system CEMS and counted against the emission limitations contained in Section 3 (A)(1) and (B)(2) of the Stipulation, such emissions are also measured by the FCC CO Boiler CEMS and shall be counted against the emission limitations contained in Section 3 (A)(3) and (B)(4) of the Stipulation (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.13. In order to accurately monitor the sulfur dioxide emission rates in pounds per hour for the FCC CO boiler stack, ExxonMobil shall perform annual source testing using EPA-approved methods (40 CFR Part 60, Appendix A, Methods 1-4 and 6/6c as appropriate for this Stipulation and Exhibit A) or an equivalent method approved by the Department and EPA, and in accordance with Section III.A.1 (ARM 17.8.106). The annual RATAs required by Sections 6(C and D) of the Stipulation (Appendix E of this permit) may substitute for the annual source tests provided that the flow rate RATA and the concentration RATA are performed simultaneously and additional calculations are made to determine and report the data in pounds per hour of sulfur dioxide (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.14. ExxonMobil shall monitor compliance with equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

K.15. Method 5, Method 6/6c and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1. ExxonMobil shall maintain COM data and submit the reports to the Department quarterly (ARM 17.8.1212).

K.16. In accordance with the Stipulation, ExxonMobil shall record, organize, report, and archive all the data specified in Section 7(C) of the Stipulation (Appendix E of this permit) (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.17. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

K.18. In accordance with Section 7 of the Stipulation (Appendix E of this permit), ExxonMobil shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report. The quarterly reports shall also include the report on the COM for the CCOB Stack – FCC CO Boiler stack (Billings/Laurel SO_2 Control Plan, approved into the SIP by EPA on May 2, 2002 and May 22, 2003).

K.19. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

K.20. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification that the SO_2 CEMS on the FCC CO Boiler was operated and maintained as required by the Stipulation;

c. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation; and

d. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

L. EU10 – ULEB/SLEB – Unsaturated Light Ends Unit, Saturated Light Ends Unit, Sour Water Strippers, Gas Compression

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
L.1, L.3, L.5, L.7, L.8	Opacity	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
L.2, L.4, L.6, L.8	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

L.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the ULEB/SLEB, that exhibit opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

L.2. ExxonMobil shall comply with the equipment leak provisions in accordance with 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

L.3. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

L.4. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

L.5. Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

L.6. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

L.7. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

L.8. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

M. EU11 – HCBL – Hydrocracking Unit

EU11a: F-651 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
M.1, M.4 M.7 M.9, M.10	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
M.2, M.5 M.7 M.9, M.10	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
M.3, M.6 M.8 M.10	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

M.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-651 Heater stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

M.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equation:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

M.3. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

M.4. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

M.5. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

M.6. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

M.7. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

M.8 ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

M.9 Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

M.10 The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

N. EU12 – H_2 Plant/HRUB - H_2 Plant, H_2 Upgrade (Recovery) Facility, MDU Replacement

EU12a: F-551 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
N.1, N.4, N.7, N.9, N.10	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
N.2, N.5, N.7, N.9, N.10	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
N.3, N.6, N.8, N.10	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

N.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-551 Heater stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

N.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equation:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

N.3. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

N.4. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

N.5. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

N.6. ExxonMobil shall monitor compliance with equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

N.7. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

N.8. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

N.9. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

N.10. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

O. EU13 – Utilities – Air Compressors/Dryers, Boiler Feed Water

EU13a: B-8 Standby Boiler House Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
O.1, O.4, O.7, O.9, O.10	Opacity	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
O.2, O.5, O.7, O.9, O.10	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$	Method 5	As Required by the Department	Semiannually
O.3, O.6, O.8, O.10	H_2S in RFG	160 ppm_v, 40 CFR 60, Subpart J	40 CFR 60, Subpart J	40 CFR 60, Subpart J	Semiannually

Conditions

O.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the Standby Boiler House stack, that exhibit an opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

O.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment calculated using the following equation:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

O.3. The RFG used in B-8 shall not exceed 160 ppm_v (230 mg/dscm or 0.1 grains/dscf) of H_2S (ARM 17.8.340 and 40 CFR 60, Subpart J).

Compliance Demonstration

O.4. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

O.5. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

O.6 ExxonMobil shall perform compliance monitoring in accordance with 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).

Recordkeeping

O.7. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

O.8. Recordkeeping shall be performed in accordance with 40 CFR 60, Subpart J for the applicable requirements as they apply to B-8 (ARM 17.8.340 and 40 CFR 60, Subpart J).

Reporting

O.9. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

O.10. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period; and

b. Certification that compliance with the reporting and recordkeeping requirements in 40 CFR 60, Subpart J was maintained.

P. EU14 – OM&U – Oil Movements & Utilities, Wastewater, High Pressure Natural Gas, Refinery Fuel Gas Supply

EU14a: Flare - Flare or Turnaround Flare
EU14b: F-10 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
P.1, P.9, P.15, P.20, P.23	Opacity F-10 Heater Stack & Turnaround Flare	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
P.2, P.9, P.15, P.20, P.23	Opacity Flare	40%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
P.3, P.10, P.15, P.22, P.23	Particulate Matter Fuel-Burning Equipment	$E = 0.882 * H^{-0.1664}$ or $E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department	Semiannually
P.4, P.11 P.16, P.21, P.23	Burning SWSOH in F-1 Crude Furnace	Electronic Sensor on Valve Supplying SWSOH	Operate Sensor on the Valve and Perform Recordkeeping	Whenever Valve is Opened	Semiannually
P.5, P.6, P.12, P.17, P.21, P.22, P.23	SO_2	Minor Flaring and 150 lb/3-Hr	Reporting & Corrective Action	As Required by the SO_2 Stipulation	At least Quarterly & as necessary
P.7, P.13, P.18, P.23	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654
P.8, P.14, P.19, P.23	Misc. Process Vents	As Required by 40 CFR 63.643	Monitoring and Testing	As Required by 40 CFR 63.644 & 645	As Required by 40 CFR 63.644 & 645

Conditions

P.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-10 Heater stack and the Turnaround Flare, that exhibit opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

P.2. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the Flare, that exhibit opacity of 40% or greater averaged over 6 consecutive minutes (ARM 17.8.304(1)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

P.3. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for existing fuel-burning equipment and new fuel-burning equipment calculated using the following equations:

For existing fuel-burning equipment (installed before November 23, 1968):
$E = 0.882 * H^{-0.1664}$ (Flare pilot gas)

For new fuel-burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$ (F-10 Heater stack and Turnaround Flare pilot gas)

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

P.4. ExxonMobil shall burn the sour water stripper overheads in the FCC CO Boiler and exhaust those emissions through the FCC CO Boiler stack, except that the sour water stripper overheads may be burned in the F-1 Crude Furnace or in the flare during periods when the FCC CO Boiler is unable to burn the sour water stripper overheads, provided that:

a. Such periods do not exceed 55 days per calendar year and 65 days for any 2 consecutive calendar years, and

b. During such periods the sour water stripper system is operating in a two-tower configuration.

(Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.5. ExxonMobil shall not allow SO_2 emissions from any flare, unless the emissions are a minor flaring event, as defined in Exhibit A-1 of the Stipulation, or are the result of start-up, shutdown, or a malfunction as defined in ARM 17.8.110 (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.6. Except for minor flaring events, ExxonMobil shall minimize SO_2 emissions from flaring. In addition, when flaring of sulfur bearing gases occurs due to a malfunction, ExxonMobil shall take immediate action to correct the malfunction (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.7. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

P.8. ExxonMobil shall comply with the miscellaneous process vent provisions in 40 CFR 63.643 as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

P.9. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

P.10. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

P.11. ExxonMobil shall operate an electronic sensor on the valve that supplies sour water stripper overheads to the F-1 Crude Furnace and/or Flare. The electronic sensor shall be electronically integrated with the Data Acquisition System (DAS) to insure that each time the valve is opened (sour water stripper overheads to Flare) the DAS automatically records the date and time that the valve is opened and the length of time the SWSOH are directed to the Flare (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.12. For flaring events in excess of 150 lbs/3-hr period, ExxonMobil shall comply with the reporting requirements identified in Section (3)(A)(5) of Exhibit A-1 of the Stipulation (Appendix E of this permit) (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.13. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

P.14. ExxonMobil shall monitor compliance with the miscellaneous process vent provisions by performing the monitoring and testing specified in 40 CFR 63.444 and 445 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

P.15. Method 5 and Method 9 test reports shall be maintained under ExxonMobil's control and must be submitted to the Department in accordance with Section III.A.1 (ARM 17.8.106).

P.16. Whenever the valve that supplies sour water stripper overheads to the Flare is opened, ExxonMobil shall log the date and time and the reasons for such action (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.17. ExxonMobil shall maintain a record of all flaring events other than de minimis activities, including reviewer's initials (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only," and ARM 17.8.1212).

P.18. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

P.19. ExxonMobil shall comply with the reporting and recordkeeping requirements for miscellaneous process vent provisions in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

P.20. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

P.21. In accordance with Section 7 of the Stipulation (Appendix E of this permit), ExxonMobil shall submit quarterly reports within 30 days of the end of each calendar quarter. The quarterly reports shall be submitted to the Department's Permitting and Compliance office in Helena and the Billings Regional Office. The quarterly report format shall consist of both a comprehensive electronic-magnetic report and a written or hard copy data summary report (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.22. For flaring events in excess of 150 lbs/3-hr period, ExxonMobil shall comply with the reporting requirements identified in Section (3)(A)(5) of Exhibit A-1 of the Stipulation (Appendix E of this permit) (Board Order signed on June 12, 1998, and subsequent revisions of March 17, 2000; this requirement is "State Only").

P.23. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification that the electronic sensor on the valve that supplies sour water stripper overheads to the Flare, was operational and that records were kept as specified by Section III.P.16;

c. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation;

d. Verification that the flaring reports (for flaring in excess of 150 lb/3-hour period), were submitted, if necessary, in addition to the previously required quarterly reporting;

e. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC; and

f. Certification of compliance with the miscellaneous process vent provisions monitoring, testing, reporting, and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

Q. EU15 – OM&S/PMAU - Oil Movements & Shipping/Asphalt PMAU

Group1 Storage Vessels: #2, #4, #5, #6, #11, #17, #19, #21, #26, #27, #28, #31, #32, #35, #36, #37, #38, #43, #44, #45, #46, #47, #82, #83, #86, #101, #102, #108, #300, #301, #303, #304, #308, #309

Group 2 Storage Vessels: #1, #3, #7, #8, #9, #10, #12 (coke storage tank), #13, #14, #15, #16, #33, #34, #40, #41, #42, #48, #49, #50, #51, #52, #53, #54, #55, #57, #58, #59, #66, #68, #69, #70, #71, #72, #73, #74, #75, #76, #77, #78, #79, #84, #87, #103, #280, #302, #305, #306, #307, #334 (in EU10), #335 (in EU10), #611 (in EU11), #508 (in EU12), #1019 (in EU10); Treaters (in EU06): 5, 7, 15, 16, 17, 19, 410.

Wastewater Provision Vessels: #22, #23, #24, #350

Subpart Kb Vessels: #101, #40

Bullet and Sphere Vessels: D60, D61, D62, D63, D64, D65, D66, and D67

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration		Reporting Requirements
			Method	Frequency	
Q.1, Q.15, Q.23, Q.30, Q.31	Opacity	20%/40% or 60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
Q.2, Q.16, Q.23, Q.31	Valves	Packing	Verification	Semiannually	Semiannually
Q.3, Q.16, Q.23, Q.31	Open-Ended Valves	Plugged or Capped	Verification	Semiannually	Semiannually
Q.4, Q.16, Q.23, Q.31	Pumps	Single Seals	Verification	Semiannually	Semiannually
Q.5, Q.16, Q.23, Q.31	Flanges	Process Compatible	Verification	Semiannually	Semiannually
Q.6, Q.17, Q.23, Q.31	Materials Processed	Non-polymerized or Polymer Modified Asphalt	Verification	Semiannually	Semiannually
Q.7, Q.16, Q.24, Q.31	PMAU Equipment Leaks	40 CFR Subpart, GGG Heavy Liquid	Exemption 60.593(d)	As Required by 60.486	Semiannually
Q.8, Q.18, Q.25, Q.31	Tank #101 and #40	40 CFR 60, Subpart Kb	In Accordance with 40 CFR 60, Subpart Kb	As Required by 60.115b and 116b	Semiannually
Q.9, Q.19, Q.26, Q.31	Hydrocarbon Emissions, Petroleum Products	Gasoline Storage Tanks – Vapor Loss Control Device	Verification	Semiannually	Semiannually
Q.10, Q.19, Q.26, Q.31	Hydrocarbon Emissions, Petroleum Products	65,000-Gallon Capacity – Vapor Loss Control Device	Verification	Semiannually	Semiannually
Q.11, Q.19, Q.26, Q.31	Hydrocarbon Emissions, Petroleum Products	Oil-Effluent Water Separator – Vapor Loss Control Device	Verification	Semiannually	Semiannually
Q.12, Q.20, Q.27, Q.31	Group 1 Storage Vessels	40 CFR 63.646	40 CFR 63.119 - 63.121	As Required by 63.123 & 63.654	As Required by 40 CFR 63.654
Q.13, Q.21, Q.28, Q.31	VOC fugitive emissions from Tank 26	515 tons per rolling 12 months	Engineering calculation/ equation	Monthly	Semiannually
Q.14, Q.22, Q.29, Q.31	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

Q.1. ExxonMobil shall maintain the operating temperature of the wetting/mixing tank below the smoking point of asphalt. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the wetting/mixing tank (PMAU) exhaust vent, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304 and ARM 17.8.752).

Q.2. All valves used shall be high-quality valves containing high-quality packing on the PMAU (ARM 17.8.752).

Q.3. All open-ended valves shall be of the same quality as the valves described above in Section III.Q.2 and they will have plugs or caps installed on the open end for the PMAU (ARM 17.8.752).

Q.4. All pumps and mills used in the PMAU shall be equipped with standard high-quality single seals (ARM 17.8.752).

Q.5. Flanges shall be equipped with process compatible gasket material on the PMAU (ARM 17.8.752).

Q.6. The PMAU may process either non-polymerized or polymer modified asphalt (ARM 17.8.749).

Q.7. ExxonMobil shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart GGG--Equipment Leaks of VOC in Petroleum Refineries. These regulations shall apply to the PMA process unit and any other equipment, as appropriate. A monitoring and maintenance program, as described under New Source Performance Standards (40 CFR Part 60, Subpart VV), shall be instituted at the PMAU (ARM 17.8.340 and 40 CFR 60, Subpart GGG).

Q.8. ExxonMobil shall comply with all applicable requirements of 40 CFR, Part 60, Standards of Performance for New Stationary Sources, Subpart Kb - Volatile Organic Liquid Storage Vessels. These regulations shall apply to Tank #40 and Tank #101 and any other tank, as appropriate. The regulations include, but are not limited to the following (ARM 17.8.340 and 40 CFR 60, Subpart Kb):

a. Any tank which construction reconstruction, or modification commenced after July 23, 1984;

b. Compliance with the requirements as specified in §60.112b, §60.113b, §60.115b, and §60.116b;

c. A fixed roof in combination with an internal floating roof;

d. An external floating roof; and

e. A closed vent system and control device.

Q.9. ExxonMobil shall not load or permit the loading of gasoline into any stationary tank with a capacity of 250 gallons or more from any tank truck or trailer, except through a permanent submerged fill pipe, unless such tank is equipped with a vapor loss control device or is a pressure tank as described in ARM 17.8.324(1) (ARM 17.8.324(3)).

Q.10. ExxonMobil shall not place, store or hold in any stationary tank, reservoir or other container of more than a 65,000-gallon capacity any crude oil, gasoline or petroleum distillate having a vapor pressure of 2.5 pounds per square inch absolute or greater under actual storage conditions, unless such tank, reservoir or other container is a pressure tank maintaining working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation (ARM 17.8.324(1)).

Q.11. ExxonMobil shall not use any compartment of any single or multiple-compartment oil-effluent water separator which compartment receives effluent water containing 200 gallons a day or more of any petroleum product from any equipment processing, refining, treating, storing or handling kerosene, or other petroleum product of equal or greater volatility than kerosene, unless such compartment is equipped with a vapor loss control device, constructed so as to prevent emission of hydrocarbon vapors to the atmosphere, properly installed, in good working order and in operation (ARM 17.8.324(2)).

Q.12. ExxonMobil shall comply with the Group 1 Storage Vessels provisions of 40 CFR 63.646 as appropriate (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Q.13. VOC emissions from Tank 26 shall not exceed 515 tons per rolling 12-month period. The VOC fugitive emissions shall be determined using the following equation (ARM 17.8.749):

$$W_{VOC} = 0.166677 \text{ lbs/ft}^3 * V_{inst} * [TVP / (12.9 \text{ psia} - TVP)]$$

Where:

V_{inst} = Air volume flowrate in standard cubic feet per day (scfd)
TVP = True vapor pressure of hydrocarbons in lb/in^2 absolute (psia)
W_{VOC} = Mass of hydrocarbon emissions in pounds per day (lbs/day)

Q.14. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

Q.15. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

Q.16. ExxonMobil shall monitor compliance with 40 CFR 60, Subpart GGG by complying with 40 CFR 60, Subpart VV. This obligation shall be used to monitor compliance with Sections III.Q.2 through III.Q.5 (ARM 17.8.340; 40 CFR 60, Subpart GGG; and ARM 17.8.1213).

Q.17. ExxonMobil shall verify that non-polymerized or polymer modified asphalt was processed in the PMAU (ARM 17.8.1213).

Q.18. ExxonMobil shall monitor compliance with 40 CFR 60, Subpart Kb by complying with §§60.113b through 60.114b (ARM 17.8.340 and 40 CFR 60, Subpart Kb).

Q.19. ExxonMobil shall monitor compliance with the hydrocarbon emission standards by ensuring that each tank, reservoir or other container is a pressure tank maintaining working pressure sufficient at all times to prevent hydrocarbon vapor or gas loss to the atmosphere, or is designed and equipped with a vapor loss control device, properly installed, in good working order and in operation (ARM 17.8.1213).

Q.20. ExxonMobil shall comply with the Group 1 Storage Vessels provisions of §§63.119 through 63.121 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Q.21. ExxonMobil shall calculate and document, by month, the total fugitive VOC emissions from Tank 26. By the 25th day of each month, ExxonMobil shall total the fugitive VOC emissions from Tank 26 for the previous 12 months to monitor compliance with the limitation in Section III.Q.13 (ARM 17.8.749).

Q.22. ExxonMobil shall monitor compliance with equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

Q.23. Recordkeeping is not required for Section III.Q.1 through Q.6 (ARM 17.8.1212).

Q.24. ExxonMobil shall maintain on-site records as required by §60.486 (ARM 17.8.340 and 40 CFR 60, Subpart GGG).

Q.25. ExxonMobil shall maintain on-site records for the monitoring of Tank 40 and Tank 101 as required by §§60.115b and 60.116b (ARM 17.8.340 and 40 CFR 63, Subpart Kb).

Q.26. Recordkeeping is not required to monitor compliance with ARM 17.8.324 (ARM 17.8.1212).

Q.27. ExxonMobil shall comply with the reporting and recordkeeping requirements of storage vessel provisions in accordance with §§63.123 and 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Q.28. ExxonMobil shall keep records as required in this permit according to Section III.Q.21 (ARM 17.8.1212).

Q.29. ExxonMobil shall comply with the Refinery MACT reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

Q.30. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

Q.31. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification that quarterly reports were submitted to the Department as required by Section 7 of the Stipulation;

c. Verification of compliance with the monitoring and recordkeeping requirements of Subpart Kb and in accordance with 40 CFR 63, Subpart CC;

d. Verification of compliance with the monitoring and recordkeeping requirements of Subpart GGG;

e. Certification of compliance with the storage vessel recordkeeping and reporting provisions in accordance with 40 CFR 63, Subpart CC;

f. Verification of compliance with the Tank 26 VOC fugitive emissions limit; and

g. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

R. EU16 – Low Sulfur Mogas

EU16a: F-1201 Heater Stack

Condition(s)	Pollutant/Parameters	Permit Limits	Compliance Demonstration Method	Compliance Demonstration Frequency	Reporting Requirements
R.1, R.8, R.15, R.19, R.20	Opacity	20%/60% for Soot Blowing	Method 9	As Required by the Department	Semiannually
R.2, R.9, R.15, R.19, R.20	Particulate Matter Fuel-Burning Equipment	$E = 1.026 * H^{-0.233}$	Method 5	As Required by the Department	Semiannually
R.3, R.10, R.15, R.19, R.20	NO_x	Ultra Low NO_x Burners 5.94 lb/hr, 0.060 lb/MMBtu	Method 7	Every 5 years	Semiannually
R.4, R.11, R.15, R.19, R.20	CO	7.77 lb/hr, 0.0785 lb/MMBtu	Method 10	As Required by the Department	Semiannually
R.5, R.12, R.16, R.20	RFG/Natural gas Consumption	811 MMscf/ rolling 12 months	Recordkeeping	Monthly	Semiannually
R.6, R.13, R.17, R.20	H_2S in RFG	160 ppm_v, 40 CFR 60, Subpart J	40 CFR 60, Subpart J	40 CFR 60, Subpart J	Semiannually
R.7, R.14, R.18, R.20	Equipment Leaks	As Required by 40 CFR 63.648	Reporting and Recordkeeping	As Required by 40 CFR 63.654	As Required by 40 CFR 63.654

Conditions

R.1. ExxonMobil shall not cause or authorize emissions to be discharged into the outdoor atmosphere, from the F-1201 Heater stack, that exhibit an opacity of 20% or greater averaged over 6 consecutive minutes (ARM 17.8.304(2)). During the building of new fires, cleaning of grates, or soot blowing, the provisions of ARM 17.8.304(1) and (2) shall apply, except that a maximum average opacity of 60% is permissible for not more than one 4-minute period in any 60 consecutive minutes. Such a 4-minute period means any 4 consecutive minutes (ARM 17.8.304(3)).

R.2. ExxonMobil shall not cause or authorize particulate matter caused by the combustion of fuel to be discharged from any stack or chimney into the outdoor atmosphere in excess of the maximum allowable emissions of particulate matter for new fuel-burning equipment calculated using the following equations:

For new fuel-burning equipment (installed on or after November 23, 1968):
$E = 1.026 * H^{-0.233}$

Where H is the heat input capacity in million Btu (MMBtu) per hour and E is the maximum allowable particulate emissions rate in pounds per MMBtu (ARM 17.8.309).

R.3. ULNBs shall be used in Furnace F-1201 to control NO_X emissions. The NO_X emissions shall not exceed 5.94 lb/hr and 0.060 lb/MMBtu (ARM 17.8.752).

R.4. The CO emissions from furnace F-1201 shall not exceed 7.77 lb/hr and 0.0785 lb/MMBtu (ARM 17.8.749).

R.5. Furnace F-1201 shall not consume more than 811 MMscf of Refinery Fuel Gas (RFG) and natural gas combined during any rolling 12-month period (ARM 17.8.749).

R.6. The RFG used in F-1201 shall not exceed 160 ppm_v (230 mg/dscm or 0.1 grains/dscf) of H_2S (ARM 17.8.340 and 40 CFR 60, Subpart J).

R.7. ExxonMobil shall comply with the equipment leak standards in 40 CFR 63.648 as appropriate and as applicable to MACT equipment leaks (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Compliance Demonstration

R.8. As required by the Department, ExxonMobil shall perform a Method 9 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

R.9. As required by the Department, ExxonMobil shall perform a Method 5 test in accordance with Section III.A.1 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.1213).

R.10. ExxonMobil shall perform a Method 7 test in accordance with Section III.A.1 every 5 years after the initial source test or according to another testing/monitoring schedule as may be approved by the Department, to monitor compliance with the NO_X limitations for furnace F-1201 found in Section III.R.3 (ARM 17.8.106 and ARM 17.8.749).

R.11. As required by the Department, ExxonMobil shall perform a Method 10 test in accordance with Section III.A.1, to monitor compliance with the CO limitations for furnace F-1201 found in Section III.R.4 (ARM 17.8.105, ARM 17.8.106, and ARM 17.8.749).

R.12. ExxonMobil shall document, by month, the total amount of RFG/natural gas consumed by furnace F-1201. By the 25^{th} of each month, ExxonMobil shall total the amount of RFG/natural gas consumed by furnace F-1201 during the previous 12 months to verify compliance with the limitation in Section III.R.5 (ARM 17.8.749).

R.13. ExxonMobil shall perform compliance monitoring in accordance with 40 CFR 60, Subpart J to monitor compliance with the requirements of 40 CFR 60, Subpart J (ARM 17.8.340 and 40 CFR 60, Subpart J).

R.14. ExxonMobil shall monitor compliance with the equipment leak standards by performing the reporting and recordkeeping requirements specified by 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Recordkeeping

R.15. All source test recordkeeping shall be performed in accordance with the appropriate test method being used and Section III.A.1 (ARM 17.8.106).

R.16. ExxonMobil shall keep records as required in this permit according to Sections III.R.12 (ARM 17.8.1212).

R.17. Recordkeeping shall be performed in accordance with 40 CFR 60, Subpart J for the applicable requirements as they apply to furnace F-1201 (ARM 17.8.340 and 40 CFR 60, Subpart J).

R.18. ExxonMobil shall comply with the reporting and recordkeeping requirements for equipment leak standards in accordance with 40 CFR 63.654 (ARM 17.8.342 and 40 CFR 63, Subpart CC).

Reporting

R.19. Any required compliance source test report(s) shall be submitted in accordance with Section III.A.1 (ARM 17.8.106).

R.20. The annual compliance certification report required by Section V.B must contain a certification stating whether ExxonMobil is in compliance with the above applicable requirements. The semiannual compliance monitoring reports must provide (ARM 17.8.1212):

a. A summary of the results of any required reference method tests performed during the reporting period;

b. Verification of compliance with the RFG/natural gas limit consumed by furnace F-1201;

c. Verification that compliance with 40 CFR 60, Subpart J was maintained; and

d. Certification that compliance was maintained with the equipment leak standards for reporting and recordkeeping requirements in accordance with 40 CFR 63, Subpart CC.

SECTION IV. NON-APPLICABLE REQUIREMENTS

Air Quality Administrative Rules of Montana (ARM) and Federal Regulations, identified as not applicable to the facility or to a specific emission unit at the time of the permit issuance, are listed below (ARM 17.8.1214). The following list does not preclude the need to comply with any new requirements that may become applicable during the permit term.

A. Facility-Wide

The following table contains non-applicable requirements, which are administrated by the Air and Waste Management Bureau of the Department of Environmental Quality.

Rule Citations	Reasons
ARM 17.8.321, ARM 17.8.323, ARM 17.8 331, ARM 17.8.332, ARM 17.8.333, and ARM 17.8.334.	These rules are not applicable because the facility is not listed in the source category cited in the rules.
ARM 17.8.316, ARM 17.8.320,	These rules are not applicable because the facility does not have the specific emission unit cited in the rules.
40 CFR 60, Subparts B, C, Ca, Cb, Cc-Ce 40 CFR 60, Subparts D, Da, Db, Dc 40 CFR 60, Subparts E-I 40 CFR 60, Subparts L-Z 40 CFR 60, Subparts AA-EE 40 CFR 60, Subparts GG-HH 40 CFR 60, Subparts KK-NN 40 CFR 60, Subparts PP-XX 40 CFR 60, Subparts AAA- DDD 40 CFR 60, Subparts FFF 40 CFR 60, Subparts HHH-LLL 40 CFR 60, Subparts NNN-WWW 40 CFR 61, Subparts B-F 40 CFR 61, Subparts H-L 40 CFR 61, Subparts N-R 40 CFR 61, Subpart T 40 CFR 61, Subparts V-W 40 CFR 61, Subpart Y 40 CFR 61, Subpart BB	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 63, Subparts B-E 40 CFR 63, Subparts AA-BB 40 CFR 63, Subparts DD-EE 40 CFR 63, Subparts HH-YY 40 CFR 63, Subparts F-I 40 CFR 63, Subparts L-O 40 CFR 63, Subparts Q-Y 40 CFR 63, Subpart GG 40 CFR 63, Subparts CCC-XXX	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 82, Subparts A & C-E 40 CFR 82, Subparts G-H	These requirements are not applicable because the facility is not an affected source as defined in these regulations.
40 CFR 72 through 40 CFR 78.	These requirements are not applicable because the facility is not an affected source as defined by the acid rain regulations.

B. Emission Units

The permit application identified applicable requirements; non-applicable requirements for individual or specific emission units were not listed. The Department has listed all non-applicable requirements in Section IV.A; these requirements relate to each specific unit as well as facility wide.

Emission Unit ID	Rule Citation	Reason
For Tanks other than Tank 40 and 101	40 CFR 60, Subparts K, Ka, Kb	These storage vessels were either built or modified prior to the effective dates and do not store materials that would trigger these regulations.
For all units other than PMAU and Low Sulfur Mogas.	40 CFR 60, Subpart GGG	These standards are not applicable to the remainder of the refinery because it was not modified after January 8, 1983.

C. Cause Orders

The permit application requested that the following Judgments be identified as non-applicable, as there are no continuous or future requirements associated with them.

Judgment	Description	Reason
Order and Final Judgment Cause No. DV 90-0068	FCC/CO Unit Operational Compliance Strategy	Per Section 12B of the order #DV90-0068, this requirement expired 2 years after the effective date as defined in section 12B. There are no continuous or future requirements.
Consent Decree, Judgment and Order Cause No. DV91-719	Coker CO Boiler Stack Opacity Monitoring	There are no on-going requirements.

SECTION V. GENERAL PERMIT CONDITIONS

A. Compliance Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(a)-(c)&(e), §1206(6)(c)&(b)

1. The permittee must comply with all conditions of the permit. Any noncompliance with the terms or conditions of the permit constitutes a violation of the Montana Clean Air Act, and may result in enforcement action, permit modification, revocation and reissuance, or termination, or denial of a permit renewal application under ARM Title 17, Chapter 8, Subchapter 12.

2. The filing of a request by the permittee for a permit modification, revocation and reissuance, or termination, or of a notification of planned changes or anticipated noncompliance does not stay any permit condition.

3. It shall not be a defense for a permittee in an enforcement action that it would have been necessary to halt or reduce the permitted activity in order to maintain compliance with the conditions of the permit. If appropriate, this factor may be considered as a mitigating factor in assessing a penalty for noncompliance with an applicable requirement if the source demonstrates that both the health, safety or environmental impacts of halting or reducing operations would be more serious than the impacts of continuing operations, and that such health, safety or environmental impacts were unforeseeable and could not have otherwise been avoided.

4. The permittee shall furnish to the Department, within a reasonable time set by the Department (not to be less than 15 days), any information that the Department may request in writing to determine whether cause exists for modifying, revoking and reissuing, or terminating the permit, or to determine compliance with the permit. Upon request, the permittee shall also furnish to the Department copies of those records that are required to be kept pursuant to the terms of the permit. This subsection does not impair or otherwise limit the right of the permittee to assert the confidentiality of the information requested by the Department, as provided in 75-2-105, MCA.

5. Any schedule of compliance for applicable requirements with which the source is not in compliance with at the time of permit issuance shall be supplemental to, and shall not sanction noncompliance with, the applicable requirements on which it was based.

6. For applicable requirements that will become effective during the permit term, the source shall meet such requirements on a timely basis unless a more detailed plan or schedule is required by the applicable requirement or the Department.

B. Certification Requirements

ARM 17.8, Subchapter 12, Operating Permit Program §1207 and §1213(7)(a)&(c)-(d)

1. Any application form, report, or compliance certification submitted pursuant to ARM Title 17, Chapter 8, Subchapter 12, shall contain certification by a responsible official of truth, accuracy and completeness. This certification and any other certification required under ARM Title 17, Chapter 8, Subchapter 12, shall state that, based on information and belief formed after reasonable inquiry, the statements and information in the document are true, accurate and complete.

2. Compliance certifications shall be submitted by October 15 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. Each certification must include the required information for the previous calendar year (i.e., September 1 – August 31).

3. Compliance certifications shall include the following:

   a. The identification of each term or condition of the permit that is the basis of the certification;

   b. The identification of the method(s) or other means used by the owner or operator for determining the status of compliance with each term and condition during the certification period, consistent with ARM 17.8.1212;

   c. The status of compliance with each term and condition for the period covered by the certification, *including whether compliance during the period was continuous or intermittent* (based on the method or means identified in ARM 17.8.1213(7)(c)(ii), as described above); and

   d. Such other facts as the Department may require to determine the compliance status of the source.

4. All compliance certifications must be submitted to the Environmental Protection Agency, as well as to the Department, at the addresses listed in the Notification Addresses Appendix of this permit.

C. Permit Shield

ARM 17.8, Subchapter 12, Operating Permit Program §1214(1)-(4)

1. The applicable requirements and non-federally enforceable requirements are included and specifically identified in this permit and the permit includes a precise summary of the requirements not applicable to the source. Compliance with the conditions of the permit shall be deemed compliance with any applicable requirements and any non-federally enforceable requirements as of the date of permit issuance.

2. The permit shield described in 1 above shall remain in effect during the appeal of any permit action (renewal, revision, reopening, or revocation and reissuance) to the Board of Environmental Review (Board), until such time as the Board renders its final decision.

3. Nothing in this permit alters or affects the following:

   a. The provisions of Section 7603 of the FCAA, including the authority of the administrator under that section;

   b. The liability of an owner or operator of a source for any violation of applicable requirements prior to or at the time of permit issuance;

   c. The applicable requirements of the Acid Rain Program, consistent with Section 7651g(a) of the FCAA;

   d. The ability of the administrator to obtain information from a source pursuant to Section 7414 of the FCAA;

   e. The ability of the Department to obtain information from a source pursuant to the Montana Clean Air Act, Title 75, Chapter 2, MCA;

f. The emergency powers of the Department under the Montana Clean Air Act, Title 75, Chapter 2, MCA; and

g. The ability of the Department to establish or revise requirements for the use of Reasonably Available Control Technology (RACT) as defined in ARM Title 17, Chapter 8. However, if the inclusion of a RACT into the permit pursuant to ARM Title 17, Chapter 8, Subchapter 12, is appealed to the Board, the permit shield, as it applies to the source's existing permit, shall remain in effect until such time as the Board has rendered its final decision.

4. Nothing in this permit alters or affects the ability of the Department to take enforcement action for a violation of an applicable requirement or permit term demonstrated pursuant to ARM 17.8.106, Source Testing Protocol.

5. Pursuant to ARM 17.8.132, for the purpose of submitting a compliance certification, nothing in these rules shall preclude the use, including the exclusive use, of any credible evidence or information relevant to whether a source would have been in compliance. However, when compliance or noncompliance is demonstrated by a test or procedure provided by permit or other applicable requirements, the source shall then be presumed to be in compliance or noncompliance unless that presumption is overcome by other relevant credible evidence.

6. The permit shield will not extend to minor permit modifications or changes not requiring a permit revision (see Sections I & J).

7. The permit shield will extend to significant permit modifications and transfer or assignment of ownership (see Sections K & N).

D. Monitoring, Recordkeeping, and Reporting Requirements
ARM 17.8, Subchapter 12, Operating Permit Program §1212(2)&(3)

1. Unless otherwise provided in this permit, the permittee shall maintain compliance monitoring records that include the following information:

   a. The date, place as defined in the permit, and time of sampling or measurement;

   b. The date(s) analyses were performed;

   c. The company or entity that performed the analyses;

   d. The analytical techniques or methods used;

   e. The results of such analyses; and

   f. The operating conditions at the time of sampling or measurement.

2. The permittee shall retain records of all required monitoring data and support information for a period of at least 5 years from the date of the monitoring sample, measurement, report, or application. Support information includes all calibration and maintenance records and all original strip-chart recordings for continuous monitoring instrumentation, and copies of all reports required by the permit. All monitoring data, support information, and required reports and summaries may be maintained in computerized form at the plant site if the information is made available to Department personnel upon request, which may be for either hard copies or computerized format. Strip-charts must be maintained in their original form at the plant site and shall be made available to Department personnel upon request.

3. The permittee shall submit to the Department, at the addresses located in the Notification Addresses Appendix of this permit, reports of any required monitoring by April 15 and October 15 of each year, or more frequently if otherwise specified in an applicable requirement or elsewhere in the permit. The monitoring report submitted on October 15 of each year must include the required monitoring information for the period of March 1 through August 31 of the previous year. The monitoring report submitted on April 15 of each year must include the required monitoring information for the period of September 1 through February 29 of the current year. All instances of deviations from the permit requirements must be clearly identified in such reports. All required reports must be certified by a responsible official, consistent with ARM 17.8.1207.

E. Prompt Deviation Reporting

ARM 17.8, Subchapter 12, Operating Permit Program §1212(3)(c)

The permittee shall promptly report deviations from permit requirements, including those attributable to upset conditions as defined in the permit, the probable cause of such deviations, and any corrective actions or preventive measures taken. To be considered prompt, deviations shall be reported as part of the routine reporting requirements under ARM 17.8.1212(3)(b) and, if applicable, in accordance with the malfunction reporting requirements under ARM 17.8.110, unless otherwise specified in an applicable requirement.

F. Emergency Provisions

ARM 17.8, Subchapter 12, Operating Permit Program §1201(13) and §1214(5), (6)&(8)

1. An "emergency" means any situation arising from sudden and reasonably unforeseeable events beyond the control of the source, including acts of God, which situation requires immediate corrective action to restore normal operation and causes the source to exceed a technology-based emission limitation under this permit due to the unavoidable increases in emissions attributable to the emergency. An emergency shall not include noncompliance to the extent caused by improperly designed equipment, lack of reasonable preventive maintenance, careless or improper operation, or operator error.

2. An emergency constitutes an affirmative defense to an action brought for noncompliance with a technology-based emission limitation if the permittee demonstrates through properly signed, contemporaneous logs, or other relevant evidence, that:

   a. An emergency occurred and the permittee can identify the cause(s) of the emergency;

   b. The permitted facility was at the time being properly operated;

   c. During the period of the emergency the permittee took all reasonable steps to minimize levels of emissions that exceeded the emission standards or other requirements in the permit; and

   d. The permittee submitted notice of the emergency to the Department within 2 working days of the time when emission limitations were exceeded due to the emergency. This notice fulfills the requirements of ARM 17.8.1212(3)(c). This notice must contain a description of the emergency, any steps taken to mitigate emissions, and corrective actions taken.

3. These emergency provisions are in addition to any emergency, malfunction or upset provision contained in any applicable requirement.

G. Inspection and Entry

ARM 17.8, Subchapter 12, Operating Permit Program §1213(3)&(4)

1. Upon presentation of credentials and other requirements as may be required by law, the permittee shall allow the Department, the administrator, or an authorized representative (including an authorized contractor acting as a representative of the Department or the administrator) to perform the following:

   a. Enter the premises where a source required to obtain a permit is located or emissions-related activity is conducted, or where records must be kept under the conditions of the permit;

   b. Have access to and copy, at reasonable times, any records that must be kept under the conditions of the permit;

   c. Inspect at reasonable times any facilities, emission units, equipment (including monitoring and air pollution control equipment), practices, or operations regulated or required under the permit; and

   d. As authorized by the Montana Clean Air Act and rules promulgated thereunder, sample or monitor, at reasonable times, any substances or parameters at any location for the purpose of assuring compliance with the permit or applicable requirements.

2. The permittee shall inform the inspector of all workplace safety rules or requirements at the time of inspection. This section shall not limit in any manner the Department's statutory right of entry and inspection as provided for in 75-2-403, MCA.

H. Fee Payment

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(f) and ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation, and Open Burning Fees §505(3)-(5) (STATE ONLY)

1. The permittee must pay application and operating fees, pursuant to ARM Title 17, Chapter 8, Subchapter 5.

2. Annually, the Department shall provide the permittee with written notice of the amount of the fee and the basis for the fee assessment. The air quality operation fee is due 30 days after receipt of the notice, unless the fee assessment is appealed pursuant to ARM 17.8.511. If any portion of the fee is not appealed, that portion of the fee that is not appealed is due 30 days after receipt of the notice. Any remaining fee, which may be due after the completion of an appeal, is due immediately upon issuance of the Board's decision or upon completion of any judicial review of the Board's decision.

3. If the permittee fails to pay the required fee (or any required portion of an appealed fee) within 90 days of the due date of the fee, the Department may impose an additional assessment of 15% of the fee (or any required portion of an appealed fee) or $100, whichever is greater, plus interest on the fee (or any required portion of an appealed fee), computed at the interest rate established under 15-31-510(3), MCA.

I. Minor Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1226(3)&(11)

1. An application for a minor permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation, or deletion, and may reference any required information that has been previously submitted.

2. The permit shield under ARM 17.8.1214 will not extend to any minor modifications processed pursuant to ARM 17.8.1226.

J. Changes not Requiring Permit Revision

ARM 17.8, Subchapter 12, Operating Permit Program §1224(1)-(3), (5)&(6)

1. The permittee is authorized to make changes within the facility as described below, provided the following conditions are met:

   a. The proposed changes do not require the permittee to obtain an air quality preconstruction permit under ARM Title 17, Chapter 8, Subchapter7;

   b. The proposed changes are not modifications under Title I of the FCAA, or as defined in ARM Title 17, Chapter 8, Subchapters 8, 9, or 10;

   c. The emissions resulting from the proposed changes do not exceed the emissions allowable under this permit, whether expressed as a rate of emissions or in total emissions;

   d. The proposed changes do not alter permit terms that are necessary to enforce applicable emission limitations on emission units covered by the permit; and

   e. The facility provides the administrator and the Department with written notification at least 7 days prior to making the proposed changes.

2. The permittee and the Department shall attach each notice provided pursuant to 1.e above to their respective copies of this permit.

3. Pursuant to the conditions above, the permittee is authorized to make Section 502(b)(10) changes, as defined in ARM 17.8.1201(30), without a permit revision. For each such change, the written notification required under 1.e above shall include a description of the change within the source, the date on which the change will occur, any change in emissions, and any permit term or condition that is no longer applicable as a result of the change.

4. The permittee may make a change not specifically addressed or prohibited by the permit terms and conditions without requiring a permit revision, provided the following conditions are met:

   a. Each proposed change does not weaken the enforceability of any existing permit conditions;

   b. The Department has not objected to such change;

   c. Each proposed change meets all applicable requirements and does not violate any existing permit term or condition; and

d. The permittee provides contemporaneous written notice to the Department and the administrator of each change that is above the level for insignificant emission units as defined in ARM 17.8.1201(22) and 17.8.1206(3), and the written notice describes each such change, including the date of the change, any change in emissions, pollutants emitted, and any applicable requirement that would apply as a result of the change.

5. The permit shield authorized by ARM 17.8.1214 shall not apply to changes made pursuant to ARM 17.8.1224(3) and (5), but is applicable to terms and conditions that allow for increases and decreases in emissions pursuant to ARM 17.8.1224(4).

K. Significant Permit Modifications

ARM 17.8, Subchapter 12, Operating Permit Program §1227(1), (3)&(4)

1. The modification procedures set forth in 2 below must be used for any application requesting a significant modification of this permit. Significant modifications include the following:

   a. Any permit modification that does not qualify as either a minor modification or as an administrative permit amendment;

   b. Every significant change in existing permit monitoring terms or conditions;

   c. Every relaxation of permit reporting or recordkeeping terms or conditions that limit the Department's ability to determine compliance with any applicable rule, consistent with the requirements of the rule; or

   d. Any other change determined by the Department to be significant.

2. Significant modifications shall meet all requirements of ARM Title 17, Chapter 8, including those for applications, public participation, and review by affected states and the administrator, as they apply to permit issuance and renewal, except that an application for a significant permit modification need only address in detail those portions of the permit application that require revision, updating, supplementation or deletion.

3. The permit shield provided for in ARM 17.8.1214 shall extend to significant modifications.

L. Reopening for Cause

ARM 17.8, Subchapter 12, Operating Permit Program §1228(1)&(2)

1. This permit may be reopened and revised under the following circumstances:

   a. Additional applicable requirements under the FCAA become applicable to the facility when the permit has a remaining term of 3 or more years. Reopening and revision of the permit shall be completed not later than 18 months after promulgation of the applicable requirement. No reopening is required under ARM 17.8.1228(1)(a) if the effective date of the applicable requirement is later than the date on which the permit is due to expire, unless the original permit or any of its terms or conditions have been extended pursuant to ARM 17.8.1220(12) or 17.8.1221(2);

   b. Additional requirements (including excess emission requirements) become applicable to an affected source under the Acid Rain Program. Upon approval by the administrator, excess emission offset plans shall be deemed incorporated into the permit;

c. The Department or the administrator determines that the permit contains a material mistake or that inaccurate statements were made in establishing the emission standards or other terms or conditions of the permit; or

d. The administrator or the Department determines that the permit must be revised or revoked and reissued to ensure compliance with the applicable requirements.

M. Permit Expiration and Renewal

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(g), §1220(11)&(12), and §1205(2)(d)

1. This permit is issued for a fixed term of 5 years.

2. Renewal of this permit is subject to the same procedural requirements that apply to permit issuance, including those for application, content, public participation, and affected state and administrator review.

3. Expiration of this permit terminates the permittee's right to operate unless a timely and administratively complete renewal application has been submitted consistent with ARM 17.8.1221 and 17.8.1205(2)(d). If a timely and administratively complete application has been submitted, all terms and conditions of the permit, including the application shield, remain in effect after the permit expires until the permit renewal has been issued or denied.

4. For renewal, the permittee shall submit a complete air quality operating permit application to the Department not later than 6 months prior to the expiration of this permit, unless otherwise specified. If necessary to ensure that the terms of the existing permit will not lapse before renewal, the Department may specify, in writing to the permittee, a longer time period for submission of the renewal application. Such written notification must be provided at least 1 year before the renewal application due date established in the existing permit.

N. Severability Clause

ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(i)&(l)

1. The administrative appeal or subsequent judicial review of the issuance by the Department of an initial permit under this subchapter shall not impair in any manner the underlying applicability of all applicable requirements, and such requirements continue to apply as if a final permit decision had not been reached by the Department.

2. If any provision of a permit is found to be invalid, all valid parts that are severable from the invalid part remain in effect. If a provision of a permit is invalid in one or more of its applications, the provision remains in effect in all valid applications that are severable from the invalid applications.

O. Transfer or Assignment of Ownership

ARM 17.8, Subchapter 12, Operating Permit Program §1225(2)&(4)

1. If an administrative permit amendment involves a change in ownership or operational control, the applicant must include in its request to the Department a written agreement containing a specific date for the transfer of permit responsibility, coverage and liability between the current and new permittee.

2. The permit shield provided for in ARM17.8.1214 shall not extend to administrative permit amendments.

P. Emissions Trading, Marketable Permits, Economic Incentives
ARM 17.8, Subchapter 12, Operating Permit Program §1226(2)

Notwithstanding ARM 17.8.1226(1) and (7), minor air quality operating permit modification procedures may be used for permit modifications involving the use of economic incentives, marketable permits, emissions trading, and other similar approaches, to the extent that such minor permit modification procedures are explicitly provided for in the Montana State Implementation Plan or in applicable requirements promulgated by the administrator.

Q. No Property Rights Conveyed
ARM 17.8, Subchapter 12, Operating Permit Program §1210(2)(d)

This permit does not convey any property rights of any sort, or any exclusive privilege.

R. Testing Requirements
ARM 17.8, Subchapter 1, General Provisions §105

The permittee shall comply with ARM 17.8.105.

S. Source Testing Protocol
ARM 17.8, Subchapter 1, General Provisions §106

The permittee shall comply with ARM 17.8.106.

T. Malfunctions
ARM 17.8, Subchapter 1, General Provisions §110

The permittee shall comply with ARM 17.8.110.

U. Circumvention
ARM 17.8, Subchapter 1, General Provisions §111

The permittee shall comply with ARM 17.8.111.

V. Motor Vehicles
ARM 17.8, Subchapter 3, Emission Standards §325

The permittee shall comply with ARM 17.8.325.

W. Annual Emissions Inventory
ARM 17.8, Subchapter 5, Air Quality Permit Application, Operation and Open Burning Fees §505 (STATE ONLY)

The permittee shall supply the Department with annual production and other information for all emission units necessary to calculate actual or estimated actual amount of air pollutants emitted during each calendar year. Information shall be gathered on a calendar-year basis and submitted to the Department by the date required in the emission inventory request, unless otherwise specified in this permit. Information shall be in the units required by the Department.

X. Open Burning
ARM 17.8, Subchapter 6, Open Burning §604, 605, and 606

The permittee shall comply with ARM 17.8.604, 605, and 606.

Y. Preconstruction Permits

ARM 17.8, Subchapter 7, Permit, Construction and Operation of Air Contaminant Sources §745 and 764 (ARM 17.8.745(1) and 764(1)(b) are STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

1. Except as specified, no person shall construct, install, alter or use any air contaminant source or stack associated with any source without first obtaining a permit from the Department or Board. A permit is not required for those sources or stacks as specified by ARM 17.8.744(1)(a)-(k).

2. The permittee shall comply with ARM 17.8.743, 744, 745, 748, and 764.

3. ARM 17.8.745(1) specifies de minimis changes as construction or changed conditions of operation at a facility holding an air quality preconstruction permit issued under Chapter 8 that does not increase the facility's potential to emit by more than 15 tons per year of any pollutant, except (STATE ENFORCEABLE ONLY until approved by the EPA as part of the SIP):

   a. Any construction or changed condition that would violate any condition in the facility's existing air quality preconstruction permit or any applicable rule contained in Chapter 8 is prohibited, except as provided in ARM 17.8.745(2);

   b. Any construction or changed conditions of operation that would qualify as a major modification under Subchapters 8, 9 or 10 of Chapter 8;

   c. Any construction or changed condition of operation that would affect the plume rise or dispersion characteristic of emissions that would cause or contribute to a violation of an ambient air quality standard or ambient air increment as defined in ARM 17.8.804;

   d. Any construction or improvement project with a potential to emit more than 15 tons per year may not be artificially split into smaller projects to avoid air quality preconstruction permitting; or

   e. Emission reductions obtained through offsetting within a facility are not included when determining the potential emission increase from construction or changed conditions of operation, unless such reductions are made federally enforceable.

4. Any facility making a de minimis change pursuant to ARM 17.8.745(1) shall notify the Department if the change would include a change in control equipment, stack height, stack diameter, stack gas temperature, source location or fuel specifications, or would result in an increase in source capacity above its permitted operation or the addition of a new emission unit. The notice must be submitted, in writing, 10 days prior to start up or use of the proposed de minimis change, or as soon as reasonably practicable in the event of an unanticipated circumstance causing the de minimis change, and must include the information requested in ARM 17.8.745(1). (STATE ENFORCEABLE ONLY until approval by the EPA as part of the SIP)

Z. National Emission Standard for Asbestos

40 CFR, Part 61, Subpart M

The permittee shall not conduct any asbestos abatement activities except in accordance with 40 CFR 61, Subpart M (National Emission Standard for Hazardous Air Pollutants for Asbestos).

AA. Asbestos

ARM 17.74, Subchapter 3, General Provisions and Subchapter 4, Fees

The permittee shall comply with ARM 17.74.301, *et seq*., and ARM 17.74.401, *et seq*. (State only)

BB. Stratospheric Ozone Protection – Servicing of Motor Vehicle Air Conditioners

40 CFR, Part 82, Subpart B

If the permittee performs a service on motor vehicles and this service involves ozone-depleting substance/refrigerant in the motor vehicle air conditioner (MVAC), the permittee is subject to all the applicable requirements as specified in 40 CFR 82, Subpart B.

CC. Stratospheric Ozone Protection – Recycling and Emission Reductions

40 CFR, Part 82, Subpart F

The permittee shall comply with the standards for recycling and emission reductions in 40 CFR 82, Subpart F, except as provided for MVACs in Subpart B.

1. Persons opening appliances for maintenance, service, repair, or disposal must comply with the required practices pursuant to §82.156.

2. Equipment used during the maintenance, service, repair or disposal of appliances must comply with the standards for recycling and recovery equipment pursuant to §82.158.

3. Persons performing maintenance, service, repair or disposal of appliances must be certified by an approved technical certification program pursuant to §82.161.

4. Persons disposing of small appliances, MVACs and MVAC-like (as defined at §82.152) appliances must comply with recordkeeping requirements pursuant to §82.166.

5. Persons owning commercial or industrial process refrigeration equipment must comply with the leak repair requirements pursuant to §82.156.

6. Owners/operators of appliances normally containing 50 or more pounds of refrigerant must keep records of refrigerant purchased and added to such appliances pursuant to §82.166.

DD. Emergency Episode Plan

The permittee shall comply with the requirements contained in Chapter 9.7 of the State of Montana Air Quality Control Implementation Plan.

Each major source emitting 100 tons per year located in a Priority I Air Quality Control Region, shall submit to the Department a legally enforceable Emergency Episode Action Plan (EEAP) that details how the source will curtail emissions during an air pollutant emergency episode. The industrial EEAP shall be in accordance with the Department's EEAP and shall be submitted according to a timetable developed by the Department, following Priority I reclassification.

EE. Definitions

Terms not otherwise defined in this permit or in the Definitions and Abbreviations Appendix of this permit, shall have the meaning assigned to them in the referenced regulations.

APPENDICES

APPENDIX A. Insignificant Emission Units

Disclaimer: The information in this appendix is not State or Federally enforceable, but is presented to assist ExxonMobil, the permitting authority, inspectors, and the public.

Pursuant to ARM 17.8.1201(22)(a), an insignificant emission unit means any activity or emissions unit located within a source that: (i) has a potential to emit less than 5 tons per year of any regulated pollutant; (ii) has a potential to emit less than 500 pounds per year of lead; (iii) has a potential to emit less than 500 pounds per year of hazardous air pollutants listed pursuant to Section 7412 (b) of the FCAA; and (iv) is not regulated by an applicable requirement, other than a generally applicable requirement that applies to all emission units subject to Subchapter 12.

List of Insignificant Activities:

The following table of insignificant sources and/or activities were provided by ExxonMobil. Because there are no requirements to update such a list, the emissions units and/or activities may change from those specified in the table.

Emission Unit ID	Description
IEU01	Warehouse building heater
IEU02	Mechanical building heater
IEU03	Operations Control Center building heater
IEU04	FCCU/HCBL Shelter heater
IEU05	Diesel Fire water pumps (2)
IEU06	Gasoline Fire water pumps (2)
IEU07	Laboratory building heater
IEU08	Laboratory equipment testing emissions
IEU09	Gasoline knock engines (3)
IEU10	Main office building heater
IEU11	Trailer heating units (8)
IEU12	Land Treatment Unit tilings/waste application
IEU13	Diesel driven cranes/lifts/trucks
IEU14	Portable diesel/gasoline pumps/compressors
IEU15	Product Coke storage tank
IEU16	Propane/Butane car/truck relief
IEU17	Propane odorant facility

APPENDIX B. Definitions and Abbreviations

"Act" means the Clean Air Act, as amended, 42 U.S. 7401, *et seq*.

"Administrative permit amendment" means an air quality operating permit revision that:

(a) Corrects typographical errors;

(b) Identifies a change in the name, address or phone number of any person identified in the air quality operating permit, or identifies a similar minor administrative change at the source;

(c) Requires more frequent monitoring or reporting by ExxonMobil;

(d) Requires changes in monitoring or reporting requirements that the Department deems to be no less stringent than current monitoring or reporting requirements;

(e) Allows for a change in ownership or operational control of a source if the Department has determined that no other change in the air quality operating permit is necessary, consistent with ARM 17.8.1225; or

(f) Incorporates any other type of change that the Department has determined to be similar to those revisions set forth in (a)-(e), above.

"Applicable requirement" means all of the following as they apply to emission units in a source requiring an air quality operating permit (including requirements that have been promulgated or approved by the Department or the administrator through rule making at the time of issuance of the air quality operating permit, but have future-effective compliance dates, provided that such requirements apply to sources covered under the operating permit):

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree or judicial or administrative order entered into or issued by the Department, that is contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any federally enforceable term, condition or other requirement of any air quality preconstruction permit issued by the Department under Subchapters 7, 8, 9 and 10 of this chapter, or pursuant to regulations approved or promulgated through rule making under Title I of the FCAA, including parts C and D;

(c) Any standard or other requirement under Section 7411 of the FCAA, including Section 7411(d);

(d) Any standard or other requirement under Section 7412 of the FCAA, including any requirement concerning accident prevention under Section 7412(r)(7), but excluding the contents of any risk management plan required under Section 7412(r);

(e) Any standard or other requirement of the acid rain program under Title IV of the FCAA or regulations promulgated thereunder;

(f) Any requirements established pursuant to Section 7661c(b) or Section 7414(a)(3) of the FCAA;

(g) Any standard or other requirement governing solid waste incineration, under Section 7429 of the FCAA;

(h) Any standard or other requirement for consumer and commercial products, under Section 7511b(e) of the FCAA;

(i) Any standard or other requirement for tank vessels, under Section 7511b(f) of the FCAA;

(j) Any standard or other requirement of the regulations promulgated to protect stratospheric ozone under Title VI of the FCAA, unless the administrator determines that such requirements need not be contained in an air quality operating permit;

(k) Any national ambient air quality standard or increment or visibility requirement under part C of Title I of the FCAA, but only as it would apply to temporary sources permitted pursuant to Section 7661c(e) of the FCAA; or

(l) Any federally enforceable term or condition of any air quality open burning permit issued by the Department under subchapter 6.

"Department" means the Montana Department of Environmental Quality.

"Emissions unit" means any part or activity of a stationary source that emits or has the potential to emit any regulated air pollutant or any pollutant listed under Section 7412(b) of the FCAA. This term is not meant to alter or affect the definition of the term "unit" for purposes of Title IV of the FCAA.

"FCAA" means the Federal Clean Air Act, as amended.

"Federally enforceable" means all limitations and conditions which are enforceable by the administrator, including those requirements developed pursuant to 40 CFR Parts 60 and 61, requirements within the Montana state implementation plan, and any permit requirement established pursuant to 40 CFR 52.21 or under regulations approved pursuant to 40 CFR Part 51, Subpart I, including operating permits issued under an EPA approved program that is incorporated into the Montana state implementation plan and expressly requires adherence to any permit issued under such program.

"Fugitive emissions" means those emissions that could not reasonably pass through a stack, chimney, vent, or other functionally equivalent opening.

"General air quality operating permit" or **"general permit"** means an air quality operating permit that meets the requirements of ARM 17.8.1222, covers multiple sources in a source category, and is issued in lieu of individual permits being issued to each source.

"Hazardous air pollutant" means any air pollutant listed as a hazardous air pollutant pursuant to Section 112(b) of the FCAA.

"Non-federally enforceable requirement" means the following as they apply to emission units in a source requiring an air quality operating permit:

(a) Any standard, rule, or other requirement, including any requirement contained in a consent decree, or judicial or administrative order entered into or issued by the Department, that is not contained in the Montana state implementation plan approved or promulgated by the administrator through rule making under Title I of the FCAA;

(b) Any term, condition or other requirement contained in any air quality preconstruction permit issued by the Department under Subchapters 7, 8, 9 and 10 of this chapter that is not federally enforceable;

(c) Does not include any Montana ambient air quality standard contained in Subchapter 2 of this chapter.

"Permittee" means the owner or operator of any source subject to the permitting requirements of this subchapter, as provided in ARM 17.8.1204, that holds a valid air quality operating permit or has submitted a timely and complete permit application for issuance, renewal, amendment, or modification pursuant to this subchapter.

"Regulated air pollutant" means the following:

(a) Nitrogen oxides or any volatile organic compounds;

(b) Any pollutant for which a national ambient air quality standard has been promulgated;

(c) Any pollutant that is subject to any standard promulgated under Section 7411 of the FCAA;

(d) Any Class I or II substance subject to a standard promulgated under or established by Title VI of the FCAA; or

(e) Any pollutant subject to a standard or other requirement established or promulgated under Section 7412 of the FCAA, including but not limited to the following:

(i) Any pollutant subject to requirements under Section 7412(j) of the FCAA. If the administrator fails to promulgate a standard by the date established in Section 7412(e) of the FCAA, any pollutant for which a subject source would be major shall be considered to be regulated on the date 18 months after the applicable date established in Section 7412(e) of the FCAA;

(ii) Any pollutant for which the requirements of Section 7412(g)(2) of the FCAA have been met but only with respect to the individual source subject to Section 7412(g)(2) requirement.

"Responsible official" means one of the following:

(a) For a corporation: a president, secretary, treasurer, or vice-president of the corporation in charge of a principal business function, or any other person who performs similar policy or decision-making functions for the corporation, or a duly authorized representative of such person if the representative is responsible for the overall operation of one or more manufacturing, production, or operating facilities applying for or subject to a permit and either:

(i) The facilities employ more than 250 persons or have gross annual sales or expenditures exceeding $25 million (in second quarter 1980 dollars); or

(ii) The delegation of authority to such representative is approved in advance by the Department.

(b) For a partnership or sole proprietorship: a general partner or the proprietor; respectively.

(c) For a municipality, state, federal, or other public agency: either a principal executive officer or ranking elected official. For the purposes of this part, a principal executive officer of a federal agency includes the chief executive officer having responsibility for the overall operations of a principal geographic unit of the agency (e.g., a regional administrator of the environmental protection agency).

(d) For affected sources: the designated representative in so far as actions, standards, requirements, or prohibitions under Title IV of the FCAA or the regulations promulgated thereunder are concerned, and the designated representative for any other purposes under this subchapter.

Abbreviations:

Alky	Alkylation
ARM	Administrative Rules of Montana
ASTM	American Society of Testing Materials
BACT	Best Available Control Technology
Btu	British Thermal Unit
CEMS	Continuous Emission Monitor System
CFRM	Continuous Flow Rate Monitor
CFR	Code of Federal Regulations
CO	carbon monoxide
COMS	Continuous Opacity Monitor System
DAS	Data Acquisition System
DEQ	Department of Environmental Quality
dscf	dry standard cubic foot
dscfm	dry standard cubic foot per minute
EEAP	Emergency Episode Action Plan
EPA	U.S. Environmental Protection Agency
EPA Method	Test methods contained in 40 CFR 60, Appendix A
EU	emission unit
FCAA	Federal Clean Air Act
FCC	Fluid Catalytic Cracker
gr	grains
HAP	hazardous air pollutant
HCBL	Hydrocracker
HF	hydrogen fluoride
HF#1	Hydrofiner #1
HF #2/3	Hydrofiners #2 and #3
H_2S	hydrogen sulfide
IEU	insignificant emissions unit
KBD	thousands of barrels per day
MACT	Maximum Achievable Control Technology
Method 5	40 CFR 60, Appendix A, Method 5
Method 9	40 CFR 60, Appendix A, Method 9
MMBtu	million British Thermal Units
NH_3	ammonia
NOx	oxides of nitrogen
NO_2	nitrogen dioxide
NSPS	New Source Performance Standard
NESHAPS	National Emission Standards for Hazardous Air Pollutant Sources
O_2	oxygen
OM&S	Oil Movement and Storage
OM&U	Oil Movement & Utilities
Pb	lead
PM	particulate matter
PM_{10}	particulate matter less than 10 microns in size
PMAU	Polymer Modified Asphalt Unit
POFO	Powerformer
psi	pounds per square inch
scf	standard cubic feet
RATA	Relative Accuracy Test Audit
SIC	Source Industrial Classification

SLEB	Saturated Light Ends Unit
SO_2	sulfur dioxide
SOx	oxides of sulfur
SWSOH	sour water stripper overheads
tpy	tons per year
ULEB	Unsaturated Light Ends
U.S.C.	United States Code
VE	visible emissions
VOC	volatile organic compound

APPENDIX C. Notification Addresses

Compliance Notifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

Montana Department of Environmental Quality
Air Resources Management Bureau
Airport Industrial Park
1371 Rimtop Dr.
Billings, MT 59105-1978

United States EPA
Air Program Coordinator
Region VIII, Montana Office
10 W. 15th Street, Suite 3200
Helena, MT 59626

Permit Modifications:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
P.O. Box 200901
Helena, MT 59620-0901

Office of Partnerships and Regulatory Assistance
Air and Radiation Program
US EPA Region VIII 8P-AR
999 18th Street, Suite 300
Denver, CO 80202-2466

APPENDIX D. Air Quality Inspector Information

Disclaimer: The information in this appendix is not State or Federally enforceable but is presented to assist ExxonMobil, permitting authority, inspectors, and the public.

1. **Direction to Plant:**

The ExxonMobil Refining and Supply Company Billings Refinery is located at 700 Exxon Road, Billings, Montana. The Yellowstone River forms the northern and northeastern boundaries and interstate Highway 90 lies along the southern border.

2. **Safety Equipment Required:**

ExxonMobil has submitted a copy of their safety indoctrination training manual titled "EXXONMOBIL BILLINGS SAFETY INDOCTRINATION TRAINING" (TDA/Rev 3/11/21/96). A copy of the manual resides in the Department's files. The manual covers Personal Protective Equipment (PPE), Hazard Communication (HAZCOM), Emergency Procedures and Alarms, Permit Procedures and Responsibilities of a Permit Receiver, Hydrogen Sulfide (H_2S) Gas Hazards, Hydrofluoric Acid and HF Alky Certification, Fall Protection, Respiratory Protection, Accident Reporting Procedures, Industrial Hygiene (IH) Procedures, Ergonomics and housekeeping.

According to page 7 of the manual, the minimum PPE requirements in the Refinery are:

- Approved hard hat
- Approved safety glasses with side shields
- Body Protection (Nomex coveralls or Nomex shirt and pants)
- Foot protection (safety shoes or substantial leather shoes, no tennis shoes, vented footwear or sandals)

Page 7 also describes a need for additional PPE such as:

- Alkylation special PPE requirements and procedures
- Hearing protection in required areas (plot plans are posted in operating shelters).
- Hand protection is highly recommended
- Goggles and faceshield to protect from a chemical splash hazard of airborne particles
- Respirator protection (must be clean shaven if respirator is required to do the job and be fit tested.)
- Seat belts recommended in plant
- Several Safety showers/eye washes located throughout the refinery. They are green and white striped buildings

3. **Facility Plot Plan:**

A facility plot plan was submitted as part of the operating permit application on June 12, 1996. A copy is available in the Department's records.

APPENDIX E. June 12, 1998 and March 17, 2000 Board Orders Adopting an SO_2 Control Plan

Although the hard copy of Appendix E has been removed from the permit, the contents of Appendix E, June 12, 1998 and March 17, 2000 Board Orders Adopting and SO_2 Control Plan remain as applicable requirements as stated in the Title V Operating Permit OP1564-01. To receive a hard copy of this appendix, please contact one of the following:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
1520 E. Sixth Ave.
P.O. Box 200901
Helena, Montana 59620-0901
Bureau Phone # : (406) 444-3490

OR

ExxonMobil Refining and Supply Company
Billings Refinery
700 Exxon Road
P.O. Box 1163
Billings, MT 59103-1163
Phone #: (406) 657-5361

APPENDIX F. September 25, 1989 Letter

Although the hard copy of Appendix E has been removed from the permit, the contents of Appendix F, September 25, 1989 Letter, remain as a reference as stated in the Title V Operating Permit OP1564-01. To receive a hard copy of this appendix, please contact one of the following:

Montana Department of Environmental Quality
Permitting and Compliance Division
Air Resources Management Bureau
1520 E. Sixth Ave.
P.O. Box 200901
Helena, Montana 59620-0901
Bureau Phone # : (406) 444-3490

OR

ExxonMobil Refining and Supply Company
Billings Refinery
700 Exxon Road
P.O. Box 1163
Billings, MT 59103-1163
Phone #: (406) 657-5361